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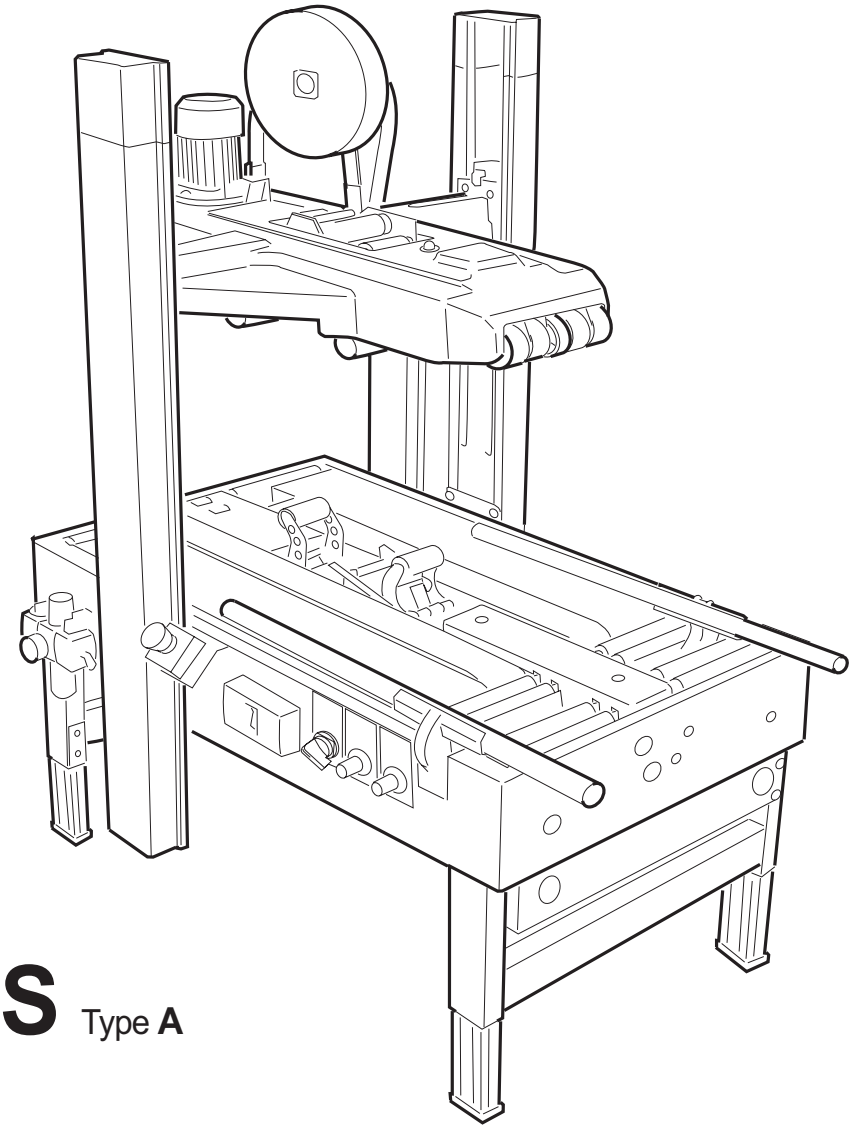

SR46-S Type **A**

NASTRATRICE AUTOMATICA
AUTOMATIC CASE SEALING MACHINE
MACHINE ENRUBANNEUSE AUTOMATIQUE
AUTOMATISCHE KARTONVERSCHLIESSMASCHINE
PRECINTADORA AUTOMATICA

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO
INSTRUCTIONS MANUAL AND SPARE PARTS LIST
MANUAL D'INSTRUCTIONS ET PIECES DETACHEES
BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE
MANUAL DE INSTRUCCIONES Y RECAMBIOS

CE

Cod. pubbl.: SMB00049K

SIAT S.p.A. - Via Puecher, 22 - 22078 TURATE (CO) ITALY - P.O. BOX 1
Tel. 02-964951 - Telefax 02-9689727
http://www.siat.com - E-Mail: siat@siat.com

Manuale di istruzioni per l'uso, la sicurezza, la manutenzione e le parti di ricambio della nastratrice SR46-S Tipo A.

Pubblicazione di proprietà della Siat S.p.A.
Via Puecher, 22 - 22078 TURATE (CO) - ITALY
Tel. 02-964.951 - Fax 02-968.9727

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Vietata la riproduzione. Tutti i diritti riservati
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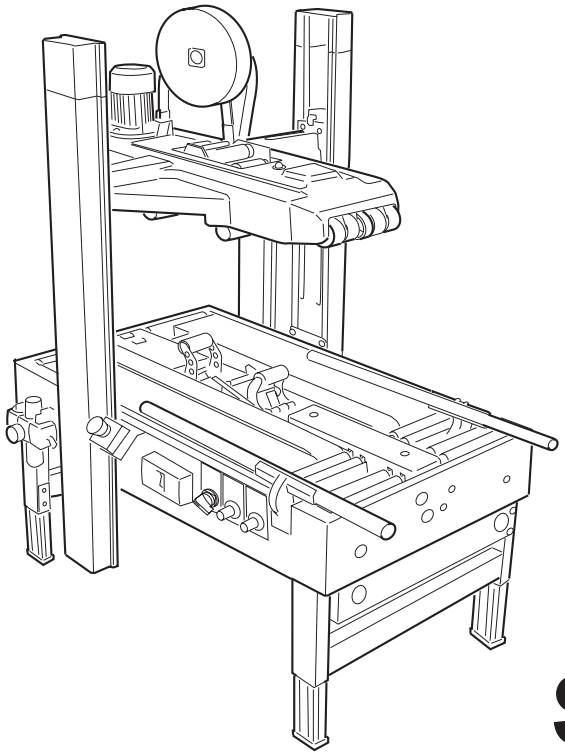
Il fabbricante si riserva di apportare modifiche alle macchine senza preavviso.

Pubblicazione n° SMB00049K
Revisione I



SR46-S Type A

NASTRATRICE AUTOMATICA AUTODIMENSIONANTE A CINGHIE DI TRASCINAMENTO SUPERIORI E INFERIORI

- Dimensione massima della scatola **h.** 750 mm **w.** 650 mm
- Nastro adesivo da 75 mm
- Velocità di avanzamento scatole 22 m/minuto
- Produzione media 650 scatole/ora

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ABBREVIAZIONI E SIGLE

TABELLA DELLE ABBREVIAZIONI, SIGLE
E TERMINI NON DI USO COMUNE UTILIZZATI
NEL MANUALE

All.	=	Allegato
Dis.	=	Disegno
Es.	=	Esempio
Fig.	=	Figura ricambi
Max.	=	Massimo
Min.	=	Minimo/a
Mod.	=	Modello della macchina
N.	=	Numero
N/A	=	Non si applica (Not Applicable)
OFF	=	Macchina ferma
ON	=	Macchina in moto
OPP	=	Polipropilene Orientato
PLC	=	Programmable Logic Control (Apparecchiatura di controllo a logica programmabile)
PP	=	Polipropilene
PTFE	=	Politetrafluoroetilene
PVC	=	Polivinilcloruro
Ric.	=	Richiami
SIAT SpA	=	Società Internazionale Applicazioni Tecniche (Società per Azioni)
Tav.	=	Tavola illustrata

w	=	Larghezza
h	=	Altezza
l	=	Lunghezza
ol	=	Lunghezza fuori tutto
cbh	=	Altezza piano di lavoro

1-PREMESSE

1.1 NORME COSTRUTTIVE

La Nastratrice automatica Mod. SR46-S è stata progettata e costruita rispondendo ai requisiti richiesti dalla legislzionealla data di costruzione.

I DOCUMENTI DI RIFERIMENTO SONO:

Direttiva 98/37/CEE Direttiva concernente il riavvicinamento delle legislazioni degli Stati membri relative alle macchine.

Direttiva 89/336/CEE Direttiva concernente il riavvicinamento delle legislazioni degli Stati membri relative alla compatibilità elettromagnetica

Direttiva 73/23/CEE concernente il ravvicinamento delle legislazioni degli Stati membri relative al materiale elettrico destinato ad essere adoperato entro taluni limiti di tensione.

UNI EN 292-1 Sicurezza del macchinario- Concetti fondamentali, principi generali di progettazione- Terminologia, metodologia di base.

UNI EN 292-2 Sicurezza del macchinario-Concetti fondamentali, principi generali di progettazione- Specifichre e principi tecnici.

UNI EN 294 Sicurezza del macchinario. Distanze di sicurezza per impedire il raggiugimento di zone pericolose con gli arti superiori.

UNI EN349 Sicurezza del macchinario. Spazi minimi per evitare lo schiacciamento di parti del corpo.

UNI EN 418 Sicurezza del macchinario. Dispositivi di arresto d'emergenza, aspetti funzionali. Principi di progettazione.

UNI EN 457 Sicurezza del macchinario- Segnali acustici di pericolo- Requisiti generali, progettazione e prove.

UNI EN 954 Sicurezza del macchinario- Parti dei sistemi di comando legate alla sicurezza- Principi generali per la progettazione.

UNI EN 050 Sicurezza del macchinario- Principi per la valutazione del rischio.

CEI EN 60204-1 Sicurezza del macchinario- Equipaggiamenti elettrici di macchine-Parte 1: Regole generali.

1.2 COME LEGGERE E UTILIZZARE IL MANUALE ISTRUZIONI

1.2.1 IMPORTANZA DEL MANUALE

Il manuale è parte integrante della macchina, le informazioni in esso contenute vi aiuteranno a mantenere la vostra macchina in perfette condizioni ed a lavorare in piena sicurezza. Custodire il manuale per tutta la durata del prodotto. Assicurarsi che qualsiasi emendamento pervenuto sia incorporato nel testo.
Passare il manuale a qualsiasi utente o successivo proprietario della macchina. Gli schemi elettrici e pneumatici sono normalmente allegati al manuale.
Per le macchine più complesse dotate di PLC o di elettronica dedicata, gli schemi possono essere attaccati al quadro comandi o consegnati a parte.

1.2.2 CONSERVAZIONE DEL MANUALE

Conservare il manuale in luogo pulito e asciutto, a portata di mano, vicino alla macchina.
Non asportare, strappare o riscrivere per alcun motivo parti del manuale
Usare il manuale senza danneggiarlo.
In caso di perdita o danneggiamento, richiedere una copia al proprio servizio assistenza/ricambi citando il codice documento.

1.2.3 CONSULTAZIONE DEL MANUALE

Il manuale è composto da:
-pagine di identificazione del documento e della macchina;
-indice analitico per argomenti;
-istruzioni e note sulla macchina:
capitoli 2÷14;
-allegati, disegni e schemi: capitoli 15÷16;
-ricambi: in fondo al manuale.
Tutte le pagine e le tabelle sono numerate e le tavole ricambi sono identificate con il numero della figura.
Tutte le note sulla sicurezza e su possibili pericoli sono identificate dal simbolo

Tutte le note di avvertimento importanti per il funzionamento sono identificati dal simbolo:

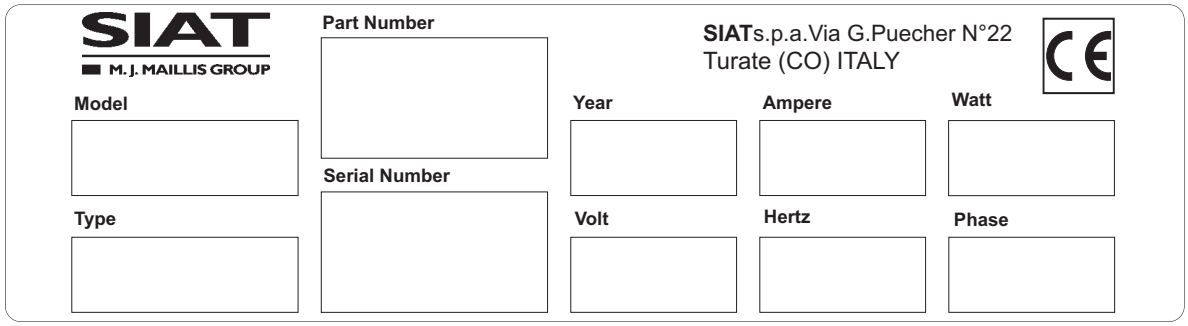
Le parti evidenziate in **grassetto** contengono particolari riferimenti a caratteristiche o note tecniche specifiche per l'argomento in questione.

1.2.4 METODOLOGIA DI AGGIORNAMENTO DEL MANUALE IN CASO DI MODIFICHE ALLA MACCHINA

Le modifiche alla macchina sono regolate da opportuna procedura interna del costruttore.
L'utilizzatore riceve il manuale completo e aggiornato insieme alla macchina e può ricevere pagine o parti del manuale contenenti emendamenti successivi alla prima pubblicazione, che dovranno essere integrate nel manuale a cura dell'utilizzatore.

2-INFORMAZIONI GENERALI

2.1 DATI DI IDENTIFICAZIONE DEL COSTRUTTORE E DELLA MACCHINA



2.2 ASSISTENZA TECNICA E RICAMBI

SIAT
M. J. MAILLIS GROUP

Via Puecher, 22
22078 TURATE (CO) - ITALY

Tel. 02-964951
Fax. 02-9682239
E-mail siat@siat.com

AGENTE/DISTRIBUTORE O SERVIZIO
ASSISTENZA TECNICA LOCALE:

2.3 GARANZIA

Nei limiti di quanto sotto espresso il fornitore si impegna a riparare tutti gli eventuali difetti di costruzione che si manifestino durante i sei (6) mesi di garanzia decorrenti dalla messa in servizio della macchina, ma comunque non oltre otto (8) mesi dalla data di spedizione.
Sono espressamente esclusi quei pezzi per i quali è previsto un normale consumo (come cinghie, rulli in gomma, guarnizioni, spazzole, etc.) nonché le parti elettriche.
Per godere della garanzia il cliente deve immediatamente notificare al fornitore i difetti che si manifestano, citando il numero di matricola della macchina. Il committente deve inviare al fornitore il pezzo difettoso per la riparazione o sostituzione. Il fornitore eseguirà le riparazioni in un ragionevole periodo di tempo. Con tale riparazione o sostituzione il fornitore adempie pienamente ai propri obblighi di garanzia. Qualora le riparazioni o sostituzioni debbano essere fatte nel luogo ove la macchina è installata, le spese di manodopera, viaggio e soggiorno dei tecnici o montatori saranno interamente a carico del committente.

l fornitore non è responsabile dei difetti derivanti da:

-Cattivo uso della macchina
-Mancata manutenzione
-Manomissioni o riparazioni eseguite dal committente.

Il fornitore non sarà inoltre responsabile di eventuali danni a persone o cose distinte dalla macchina oggetto della garanzia, né di eventuale mancata produzione.

Per i materiali non costruiti dal fornitore, come apparecchiature elettriche e motori, questi concede al committente la stessa garanzia che egli riceve dai fornitori di detti materiali.

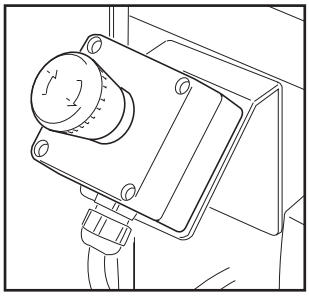
Il fornitore non garantisce la conformità delle macchine alle disposizioni di legge vigenti nei paesi extra U.E. in cui esse verranno installate ed in particolare a quelle relative alla prevenzione degli infortuni ed all'inquinamento. L'adeguamento delle macchine alle suddette norme è posto a carico del committente il quale si assume ogni relativa responsabilità, mandandone indenne il fornitore ed impegnandosi a sollevarlo da ogni responsabilità a qualsivoglia pretesa dovesse insorgere da terzi per effetto dell'inosservanza delle norme stesse.

3-SICUREZZA

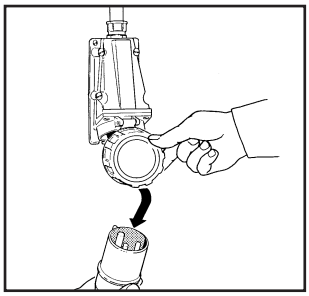
3.1 AVVERTENZE GENERALI DI SICUREZZA

Leggere attentamente tutte le istruzioni prima di utilizzare la macchina; prestare particolare attenzione alle sezioni dove si incontra questo simbolo

La macchina é dotata di un pulsante STOP EMERGENZA a ritenuta posto sul lato operatore della macchina; se premuto arresta la macchina in qualsiasi punto del ciclo senza disattivare l'impianto pneumatico.



Staccare la spina di alimentazione dalla presa di corrente prima di ogni operazione di manutenzione.



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Conservare questo manuale di istruzioni: le informazioni in esso contenute vi aiuteranno a mantenere la vostra macchina in perfette condizioni ed a lavorare in piena sicurezza

3.2 DEFINIZIONE DELLE QUALIFICHE DEGLI OPERATORI

- Operatore conduttore di macchina;
- Manutentore meccanico;
- Manutentore elettrico;
- Tecnico del costruttore

Il lavoro con la macchina può essere svolto solo da persone aventi le qualifiche definite qui di seguito.
Sarà responsabilità dell'utilizzatore definire le persone qualificate ai vari livelli di intervento e dare alle stesse l'idoneo addestramento e le consegne operative come definite in questo manuale.

QUALIFICA 1

CONDUTTORE DI MACCHINA
Operatore addestrato e abilitato alla conduzione della macchina attraverso l'uso dell'interruttore generale e dello stop di emergenza, introduzione della scatola, regolazioni delle dimensioni macchina sulla scatola, cambio nastro, avviamento, fermata e ripristino della produzione.
NOTA: i responsabili di stabilimento e di reparto presteranno estrema attenzione che il conduttore macchina sia stato addestrato a tutte le operazioni prima di cominciare a lavorare con la macchina.

QUALIFICA 2

MANUTENTORE MECCANICO
Tecnico qualificato in grado di condurre la macchina come il CONDUTTORE MACCHINA e in più di farla funzionare con protezioni disabilitate, di intervenire sugli organi meccanici per regolazioni, manutenzioni, riparazioni.
Non è abilitato a interventi su impianti elettrici sotto tensione.

QUALIFICA 2a

MANUTENTORE ELETTRICISTA
Tecnico qualificato in grado di condurre la macchina come il CONDUTTORE MACCHINA e in più di farla funzionare con protezioni disabilitate, di intervenire sulle regolazioni e sugli impianti elettrici per manutenzione e riparazione.
Opera in presenza di tensione all'interno di quadri elettrici e scatole di derivazione, apparecchiature di controllo etc.

QUALIFICA 3

TECNICO SPECIALIZZATO DEL COSTRUTTORE
Tecnico qualificato del costruttore o del suo rappresentante per operazioni complesse, quando concordato con l'utilizzatore.

3.3 PRESCRIZIONI PER INTERAGIRE IN MODO SICURO CON LA MACCHINA

Il lavoro con la macchina può essere svolto solo da persone aventi le qualifiche definite al paragrafo 3.6 che segue.
Sarà responsabilità dell'utilizzatore definire le persone qualificate ai vari livelli di intervento e dare alle stesse l'idoneo addestramento e le consegne operative come definite in questo manuale.

3.4 STATI DELLA MACCHINA

Elenco degli stati possibili con questa macchina:
- Marcia automatica;
- Marcia con protezioni ridotte;
- Arresto con interruttore generale;
- Arresto con pulsante di emergenza ritenuto;
- Collegamento elettrico disconnesso;
- Collegamento aria compressa disconnesso.

3.5 NUMERO DEGLI OPERATORI

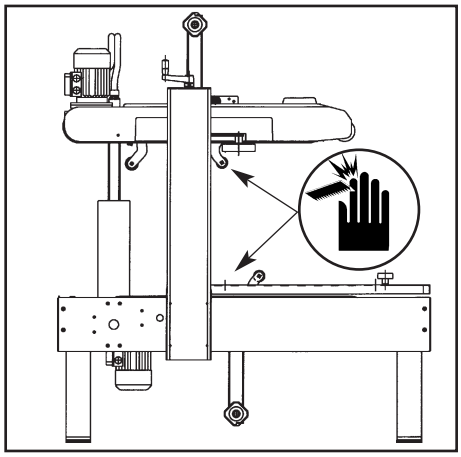
Le operazioni sotto descritte sono state analizzate dal fabbricante; il numero degli operatori indicato per ciascuna di esse è adeguato per svolgere la funzione in modo ottimale. Un numero di operatori inferiore o superiore potrebbe mettere in pericolo la sicurezza del personale coinvolto.

3.6 QUALIFICA DEGLI OPERATORI

È indicata per ogni operazione la qualifica minima dell'operatore.

OPERAZIONE	STATO DELLA MACCHINA	QUALIFICA OPERATORE	NUMERO OPERATORI
Installazione e preparazione all'uso.	Marcia con protezioni ridotte.	**2 e 2a**	2
Regolazione dimensione scatola.	Ferma con STOP EMERGENZA ritenuto.	**1**	1
Sostituzione nastro.	Ferma con STOP EMERGENZA ritenuto.	**1**	1
Sostituzione lame.	Collegamento elettrico e pneumatico disconnesso.	**2**	1
Sostituzione cinghie di trascinamento.	Collegamento elettrico e pneumatico disconnesso.	**2**	1
Manutenzione meccanica ordinaria.	Collegamento elettrico e pneumatico disconnesso.	**2**	1
Manutenzione elettrica ordinaria.	Collegamento elettrico e pneumatico disconnesso.	**2a**	1
Manutenzione meccanica straordinaria.	Marcia con protezioni ridotte.	**3**	1
Manutenzione elettrica straordinaria.	Marcia con protezioni ridotte.	**3**	1

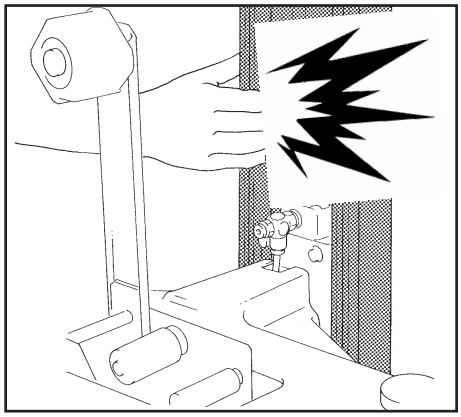
3.7 PERICOLI RESIDUI



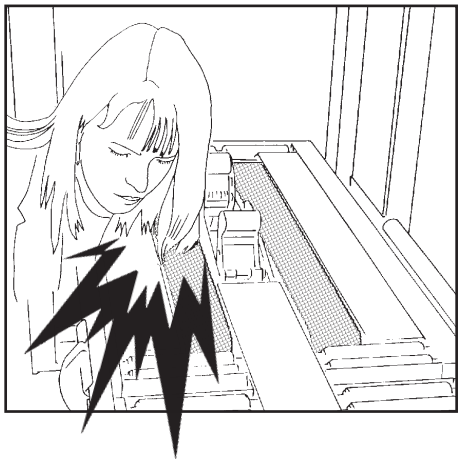
La nastratrice SR46-S è stata progettata in conformità alle norme CE 392 con vari accorgimenti e dispositivi antinfortunistici, che non devono mai essere rimossi o disattivati.

Nonostante le precauzioni per la sicurezza adottate dai progettisti, è essenziale che l'operatore e i tecnici addetti alla manutenzione siano preventivamente informati dei seguenti pericoli residui non eliminabili:

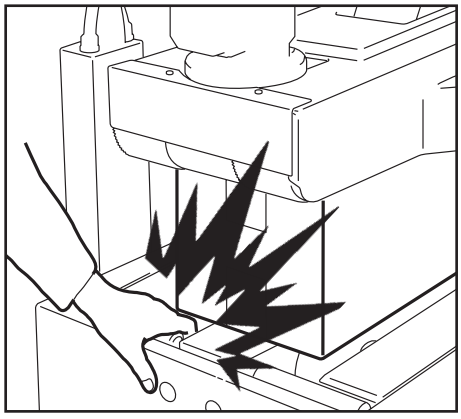
ATTENZIONE! Lame taglio nastro.
Non rimuovere il dispositivo di sicurezza che copre la lama di taglio delle unità nastranti superiore ed inferiore.
Le lame sono estremamente taglienti. Un errore può causare severe ferite.



ATTENZIONE! Colonne pneumatiche a scorrimento.
Tenere le mani lontano dalle colonne, pericolo di schiacciamento.

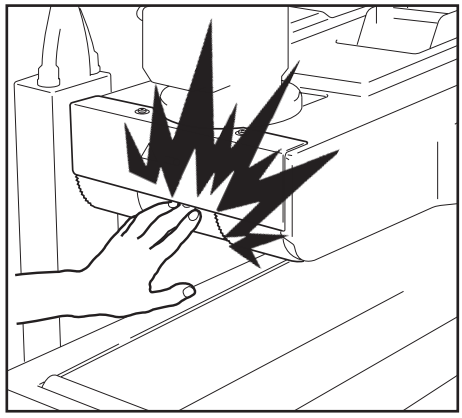


ATTENZIONE! Cinghie di trascinamento superiori ed inferiori.
Non avvicinare mai alla macchina capelli o indumenti liberi come foulard, cravatte o maniche larghe. Anche se protette, le cinghie di trascinamento possono essere pericolose.



ATTENZIONE! Cavità sul piano di scorrimento uscita scatola.
Non inserire mai le mani all'interno della macchina durante il moto.
Pericolo di schiacciamento.

ATTENZIONE! Cinghie di trascinamento superiori.
Non accompagnare mai, con le mani, il movimento della cinghia di trascinamento.
Pericolo di schiacciamento.



3.8 RACCOMANDAZIONI E MISURE DI PREVENZIONE CONTRO I PERICOLI RESIDUI CHE NON POSSONO ESSERE ELIMINATI

L'operatore è invitato a restare nella posizione di lavoro indicata al parag. 12.1, a non toccare mai le cinghie in movimento, a non toccare mai nessun punto dell'interno macchina in funzione, a non mettere le mani in nessuna cavità, ad alimentare la macchina tenendo le mani nella giusta posizione (vedere parag. 4.9), a prestare molta attenzione alle lame durante il cambio nastri.

3.9 MEZZI PERSONALI DI PROTEZIONE

(Occhiali, guanti, elmetto, scarpe, filtri/respiratori, cuffie antirumore).
Nessuno, se non raccomandati dall'utilizzatore.

3.10 DIVIETI RELATIVI A COMPORTAMENTI NON CONSENTITI O NON CORRETTI, RAGIONEVOLMENTE PREVEDIBILI

- Non cercate mai di contrastare l'azione di trascinamento della scatola.
  Utilizzare sempre il pulsante STOP EMERGENZA.

- Non utilizzate la macchina con le protezioni smontate.

- Non smontare le protezioni.

- Solo il personale autorizzato avrà facoltà di effettuare le regolazioni, riparazioni e manutenzioni che richiedono l'azionamento della macchina con le protezioni ridotte.
Durante tali operazioni l'accesso alla macchina sarà ristretto ai soli operatori aventi idonee qualifiche. Al termine di ogni intervento sarà subito ripristinato lo stato della macchina con protezioni attive.

- Le operazioni di pulizia e manutenzione devono essere fatte dopo aver tolto l'energia elettrica.

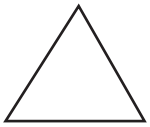
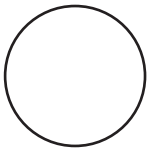
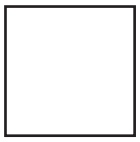
- Pulire con panni asciutti o blande soluzioni detergenti. Non usare solventi, benzine etc.

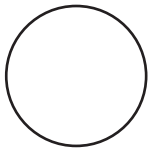
- Non modificare la macchina o parti di macchina. La Siat non risponde delle conseguenze.

- Consigliamo di richiedere eventuali modifiche alla Siat S.p.A.

- Seguire attentamente le istruzioni di installazione di questo manuale.
  La Siat S.p.A. non risponde di inconvenienti causati da caso contrario.

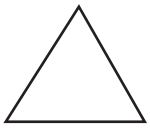
3.11 RIEPILOGO DEGLI AVVERTIMENTI, ETICHETTE, TARGHE, DISEGNI RIPORTATI SULLA MACCHINA

	LEGENDA SIMBOLI	LEGENDA COLORI
	PERICOLO E PARTI IN MOVIMENTO	COLORE GIALLO
	OBBLIGO/DIVIETO	COLORE ROSSO
	COMANDI ED INFORMAZIONI	COLORE AZZURRO

a 

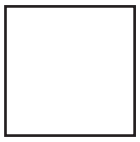
Evidenzia che il fine corsa che regola l'altezza della testata superiore non deve essere sbloccato in assenza di pressione aria.

Codice etichetta: 3.0.010604.96/A

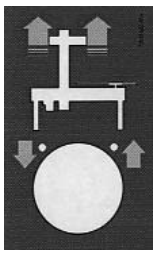
b 

Avvisa l'operatore di non toccare la leva che aziona la valvola per il sollevamento della testata superiore.

Codice etichetta: 3.0.01029.96A

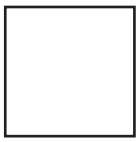
c 

Indica il selettore sollevamento/abbassamento testata che facilita l'estrazione dell'unità nastrante inferiore.

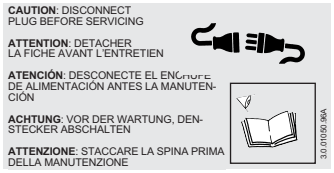


Codice etichetta: 3.0.01047.96A

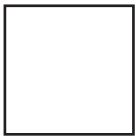
3-SICUREZZA

d 

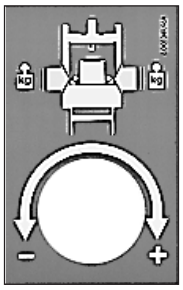
Indica che é obbligatorio scollegare la spina dalla presa di alimentazione prima di iniziare ogni operazione di manutenzione.


CAUTION: DISCONNECT PLUG BEFORE SERVICING
ATTENTION: DETACHER LA FICHE AVANT L'ENTRETIEN
ATENCIÓN: DESCONECTE EL ENCHUFE DE ALIMENTACIÓN ANTES LA MANUTENCIÓN
ACHTUNG: VOR DER WARTUNG, DEN STECKER ABSCHALTEN
ATTENZIONE: STACCARE LA SPINA PRIMA DELLA MANUTENZIONE

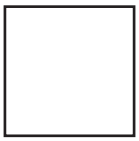
Codice etichetta: 3.0.01050.96A

e 

Indica la manopola per la regolazione della pressione delle guide laterali sulla scatola.

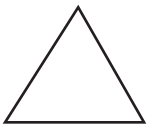


Codice etichetta: 3.0.01049.96A

f 

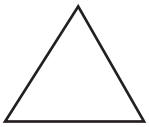
Indica la manopola per la regolazione del peso della testata sulla scatola.

Codice etichetta: 3.0.01048.96A

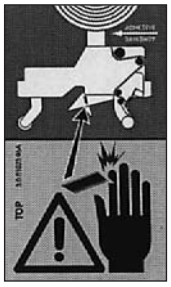
g 

Indica il pericolo di lama tagliente dell'unità nastrante.

Codice etichetta: 3.0.01028.96A

h 

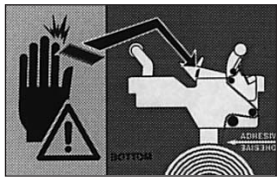
Indica il percorso nastro dell'unità nastrante superiore e il pericolo di lama tagliente.



Codice etichetta: 3.0.01023.96A

i

Indica il percorso nastro dell'unità nastrante inferiore e il pericolo di lama tagliente.



Codice etichetta: 3.0.01024.96A

l

Indica la direzione di marcia delle cinghie di trascinamento.

Codice etichetta: 3.0.01040.96A

m

Indica la presenza dell'aria nel circuito (indicatore rosso visibile).

Codice etichetta: 3.0.01035.96A

n

Avvisa l'operatore di non toccare lo scivolo che aziona le valvole per la chiusura/apertura delle guide scatola laterali.

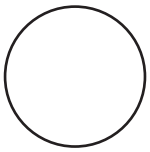
Codice etichetta: 3.0.01027.96A

o

Avvisa l'operatore di far attenzione a non introdurre niente nelle cavità delle guide scatola laterali.

Codice etichetta: 3.0.01036.96A

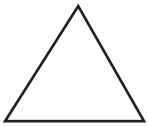
p



Avvisa l'operatore di non toccare le colonne all'interno delle quali é collocato il cilindro di sollevamento della testata superiore.

Codice etichetta: 3.0.01041.96A

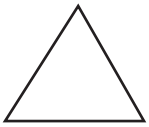
q



Indica il pericolo delle cinghie di trascinamento superiore in movimento.

Codice etichetta: 3.0.01030.96A

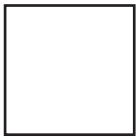
r



Indica il pericolo delle cinghie di trascinamento inferiore in movimento.

Codice etichetta: 3.0.01031.96A

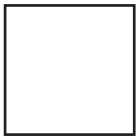
s



Indica i comandi di marcia/arresto ed evidenzia che all'interno della scatola dell'interruttore magnetotermico circola corrente elettrica.

Codice etichetta: 3.0.01090.96A

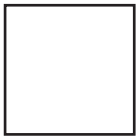
t



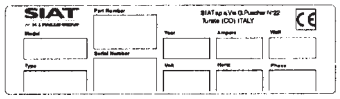
Indica il punto in cui il filo di protezione è collegato al corpo macchina (messa a terra).

Codice etichetta: 3.0.01039.96A

u



Riporta i dati di identificazione del modello, numero di matricola e fabbricante della macchina.



Codice etichetta: SBC0000629

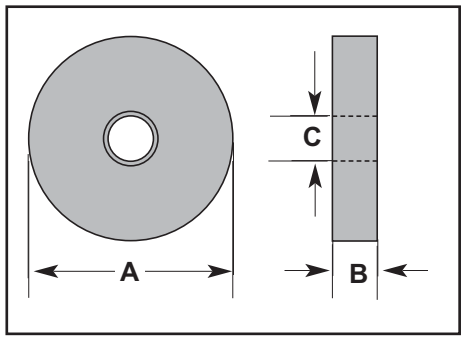
4-INFORMAZIONI PRELIMINARI SULLA MACCHINA

4.1. DESCRIZIONE GENERALE DELLA MACCHINA

Nastratrice automatica con cinghie di trascinamento superiori e inferiori autodimensionante, adatta per sigillare scatole di diverso formato.

4.2. DATI TECNICI

-Produzione media= 650 scatole/ora
-Alimentazione standard= 230/400 V, 50 Hz 3Ph
-N. 2 motori (0,18 HP) 0,12 kW
-Unità nastranti K12, lunghezza nastro 75 mm
-Peso= 165 kg
-Velocità cinghie= 22 m/minuto
-Aria compressa= max. 6 bar



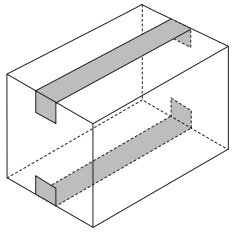
A = 410 mm max
B =75 mm
C = 76 mm

4.3 DIMENSIONI NASTRO

Nastri adesivi idonei:
PVC
OPP
CARTA ADESIVA

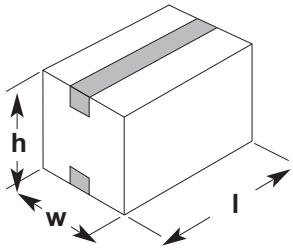
4.4 USO PREVISTO

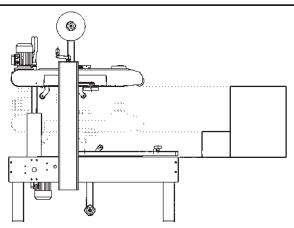
La sigillatura con nastro adesivo di scatole delle dimensioni (in millimetri) indicate al paragrafo 4.5 tramite l'applicazione contemporanea di due strisce di nastro adesivo (una sulla parte superiore ed una sulla parte inferiore delle scatole).
La macchina con l'impianto elettrico standard non è adatta per l'impiego in atmosfera esplosiva dove sono necessari componenti antideflagranti e/o motori ad aria.



4.5 GAMMA DI DIMENSIONI SCATOLE

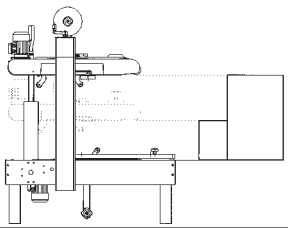
La nastratrice SR46-S è adatta per sigillare automaticamente scatole le cui dimensioni rientrano nella gamma sottoindicata (parte 1)
Per la chiusura di scatole aventi altezza oltre 750 mm mm è possibile alzare la posizione delle colonne fisse, come indicato nel disegno di seguito riportato (parte 2)





1 COLONNE FISSE IN POSIZIONE BASSA

MISURE SCATOLA		MIN	MAX
	L	**150**	
	W	**170**	**650**
	H	**130**	**750**



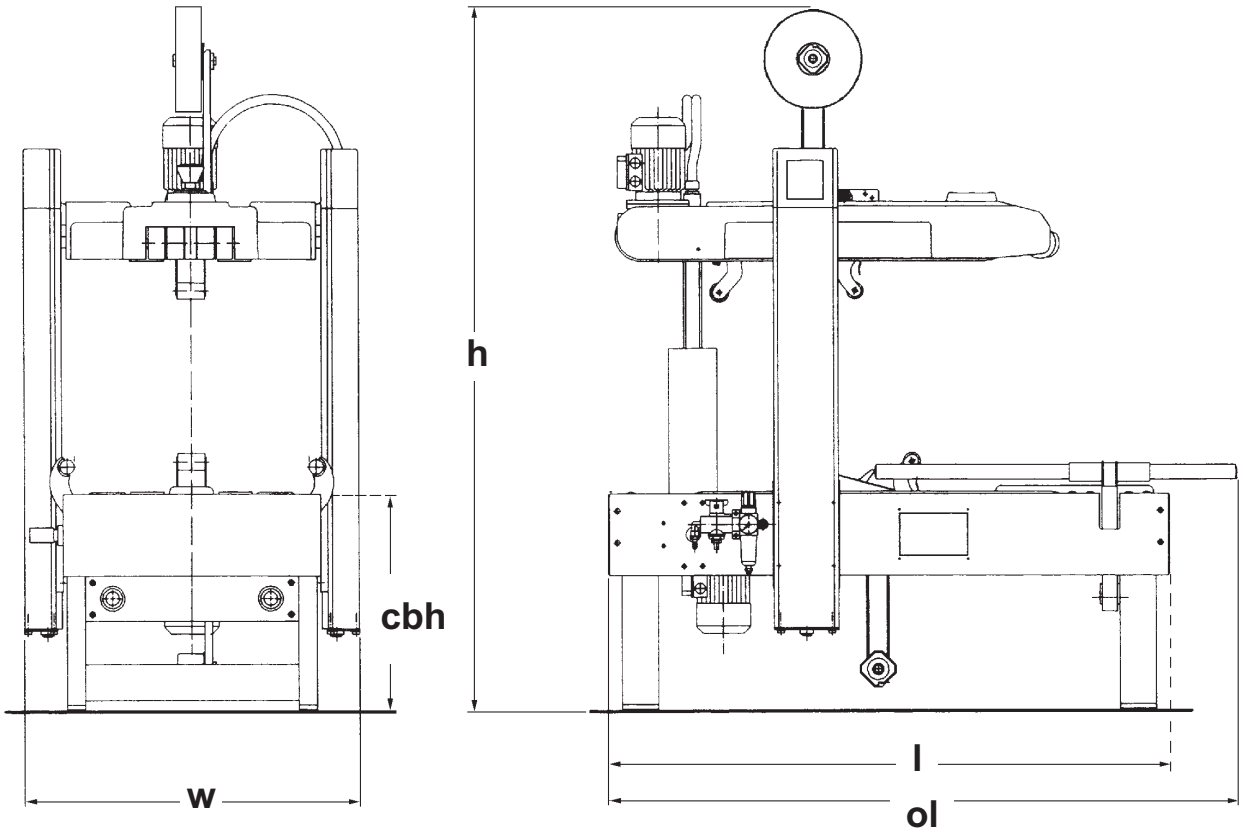
2 COLONNE FISSE IN POSIZIONE ALTA

MISURE SCATOLA		MIN	MAX
	L	**150**	
	W	**170**	**650**
	H	**340**	**930**

NOTE

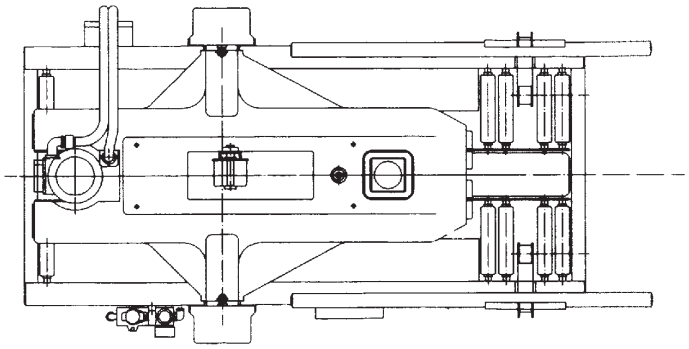
- La lunghezza scatola (L) si riferisce alla misura nel senso della nastratura.
- Le scatole devono avere un rapporto L/H (LUNGHEZZA/ALTEZZA) superiore a 0,5. Per scatole con rapporto inferiore occorre effettuare una prova per accertare la perfetta funzionalità, che dipende da vari fattori tra i quali peso e rigidezza delle scatole.
- In alcuni casi, il fabbricante può apportare modifiche speciali alla nastratrice SR46-S (SMB00049K) per sigillare scatole di formati più piccoli o più grandi di quelli qui indicati. In caso di interesse contattare il servizio di Assistenza Tecnica Siat

4.6 DIMENSIONI



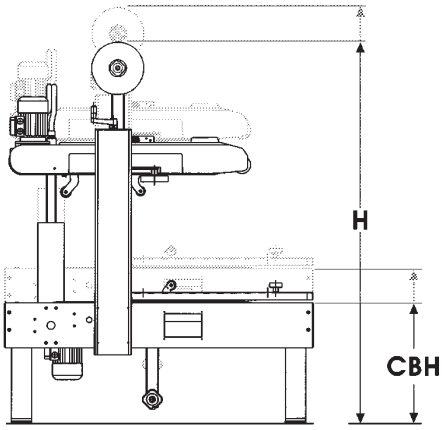
DIMENSIONI MACCHINA

l = lunghezza 1240 mm
w = larghezza 940 mm
h = altezza 1275÷2025 mm
ol = lunghezza fuori tutto, comprensiva delle barre centratore: 1390 mm
cbh = altezza piano di lavoro: vedere parag. 4.7.



4.7 ALTEZZA PIANO DI LAVORO

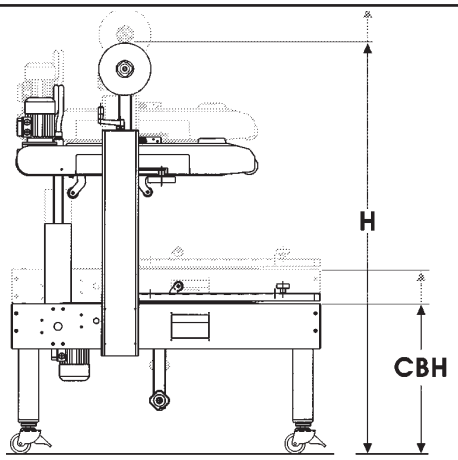
La nastratrice SR46-S consente un ampio margine di regolazione dell'altezza del piano di scorrimento delle scatole. Varie combinazioni possono essere ottenute con gli accessori opzionali AS77 (ruote) e AS80 (gambe), facendo riferimento alla tabella della pagina seguente.



A CON GAMBE STANDARD

ALTEZZA PIANO RULLIERE	MIN	MAX
CBH	**485**	**825**

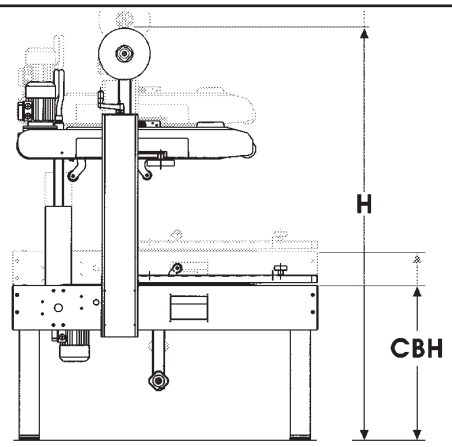
DIMENSIONI GENERALI	MIN	MAX
H	**1275**	**2025**
L	**1240**	**1240**
W	**940**	**940**



B CON RUOTE AS77 (OPZIONALI)

ALTEZZA PIANO RULLIERE	MIN	MAX
CBH	**585**	**925**

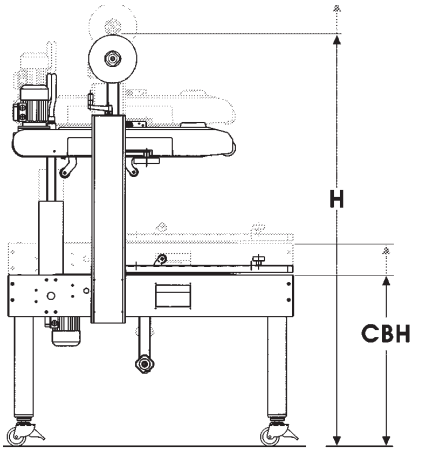
DIMENSIONI GENERALI	MIN	MAX
H	**1375**	**2125**
L	**1240**	**1240**
W	**940**	**940**



C CON GAMBE AS80 (OPZIONALI)

ALTEZZA PIANO RULLIERE	MIN	MAX
CBH	**645**	**1135**

DIMENSIONI GENERALI	MIN	MAX
H	**1435**	**2335**
L	**1240**	**1240**
W	**940**	**940**



D CON GAMBE AS80 E RUOTE AS77(OPZIONALI)

ALTEZZA PIANO RULLIERE	MIN	MAX
CBH	**745**	**1235**

DIMENSIONI GENERALI	MIN	MAX
H	**1535**	**2435**
L	**1240**	**1240**
W	**940**	**940**

4.8 COMPONENTI PRINCIPALI

La macchina è composta da:

N. 1 bancale
N. 4 gambe regolabili
N. 2 colonne
N. 2 unità nastranti
N. 1 testata superiore
N. 1 motorizzazione superiore
N. 1 motorizzazione inferiore
N. 2 motori elettrici
N. 1 tasto STOP EMERGENZA
N. 1 interruttore principale ON/OFF

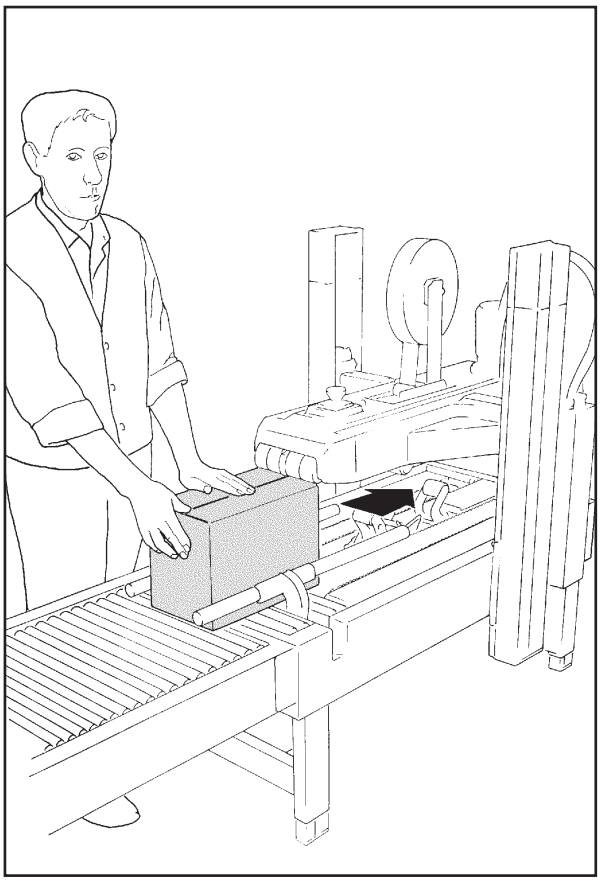
Per le caratteristiche tecniche dei componenti elettrici, vedere la sezione 15-ALLEGATI

4.9 FLUSSO OPERATIVO

Una volta riempita la scatola, ripiegarne le falde superiori e spingerla contro la leva che comanda la salita della testata superiore. Introdurre la scatola nella macchina fino a sovrastare le cinghie di trascinamento, la scatola verrà così trascinata dalle cinghie non appena il gruppo superiore sarà ridisceso.

Tenere le mani sempre e solo nella posizione indicata nella Tavola.

La scatola viene poi automaticamente sigillata con nastro adesivo sul lato superiore e su quello inferiore ed espulsa sulla rulliera di uscita.



4.10 MISURA DEL LIVELLO DI RUMORE

Pressione acustica rilevata ad una distanza di 1 metro dalla macchina con nastro adesivo inserito: 73 dB.
Pressione acustica ad una altezza di 1,6 metri dalla macchina con nastro adesivo inserito: 73 dB.
Rilevazioni effettuate con uno strumento tipo SPYRI-MICROPHON

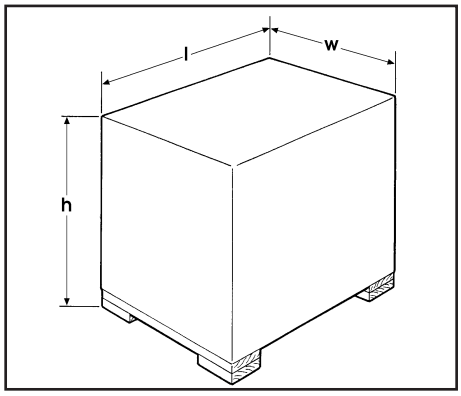
5-TRASPORTO-MOVIMENTAZIONE-IMMAGAZZINAMENTO

5.1 TRASPORTO E MOVIMENTAZIONE MACCHINA IMBALLATA

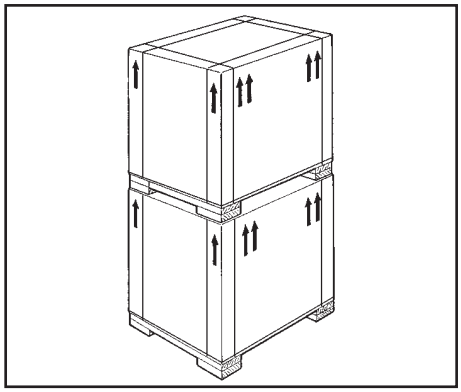
La macchina è fissata al bancale con N. 4 bulloni passanti e può essere sollevata con un normale carrello a forche.
L'imballo standard è adatto per viaggiare via terra e per via aerea.
Imballo via mare a richiesta.

DIMENSIONE IMBALLO

l = lunghezza 1400 mm
w = larghezza 1000 mm
h = altezza 1300 mm
Peso kg. 210

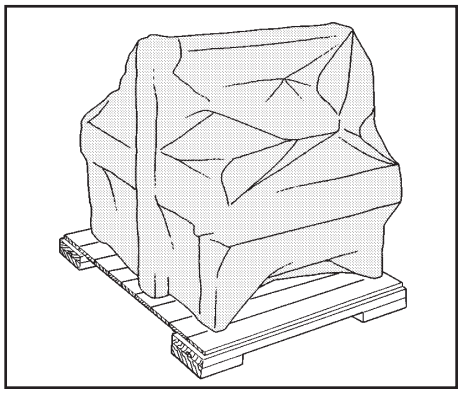


Durante la fase di trasporto è possibile sovrapporre un massimo di 2 macchine.



5.2 IMBALLO OLTREMARE (OPZIONALE)

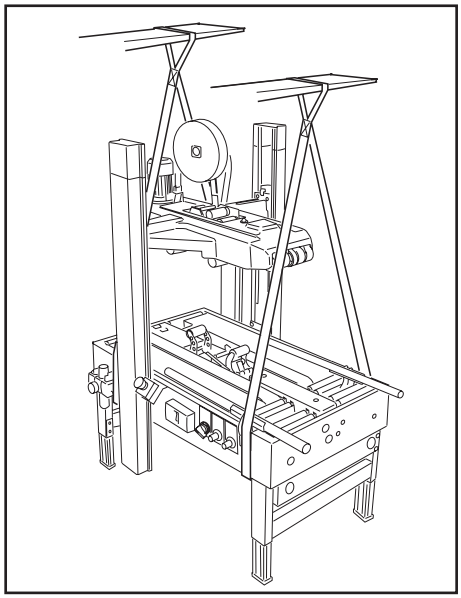
Le macchine spedite via mare sono avvolte in un sacco in materiale accoppiato alluminio/poliestere/ politene, contenente sali disidratanti.



5.3 TRASPORTO E MOVIMENTAZIONE MACCHINA DISIMBALLATA

La macchina disimballata non deve essere trasportata se non per brevissime distanze e all'interno dei reparti. Il trasporto della macchina priva di imballo può causare danni e infortuni. Nel caso si rendesse necessario spostarla, imbracarla con cinghie di sollevamento come mostrato in tavola e sollevarla con un carrello elevatore o con una gru.

DIMENSIONI MACCHINA
lunghezza 1240 mm
larghezza 940 mm
altezza min.1275 max. 2025 mm
peso kg 165

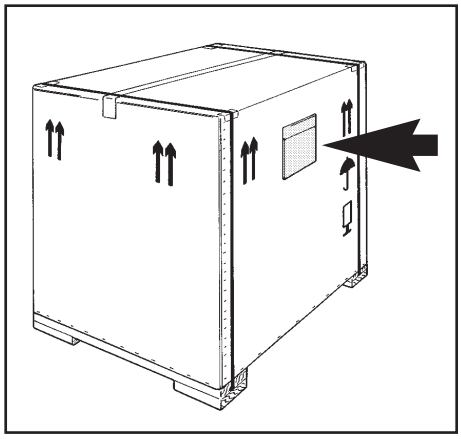


5.4 IMMAGAZZINAMENTO DELLA MACCHINA IMBALLATA O DISIMBALLATA

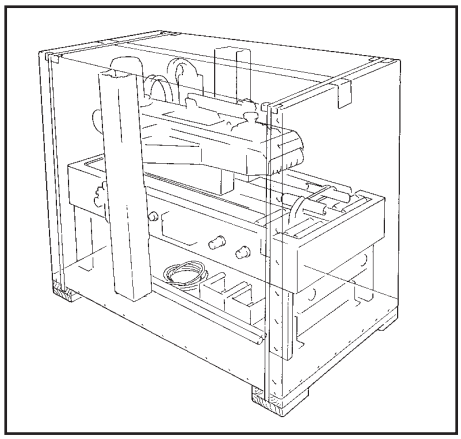
Precauzioni per una lunga inattività della macchina:
-immagazzinare in luogo asciutto e pulito;
-se la macchina è disimballata è necessario proteggerla dalla polvere e non sovrapporre alcunché;
-se le macchine sono imballate si possono sovrapporre per un massimo di 2.

6-DISIMBALLO

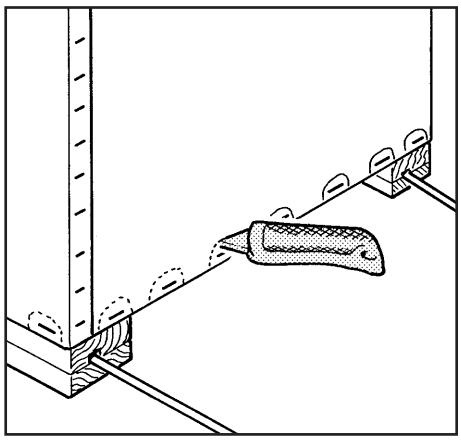
6.1 Busta all'esterno dell'imballo contenente le istruzioni per il disimballo della macchina.



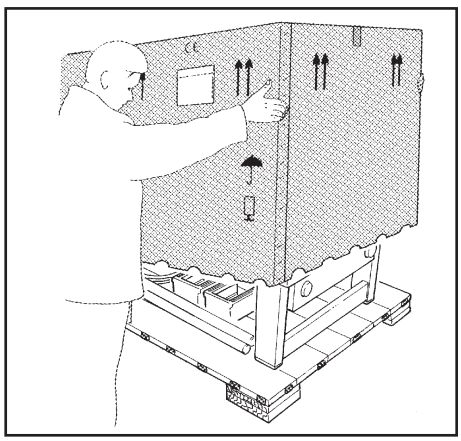
Posizione della macchina all'interno dell'imballo.



Tagliare le regge in Polipropilene.
Tagliare con un cutter la parte del cartone fissata con le graffe, lungo tutto il perimetro dell'imballo. (Oppure, se si hanno attrezzi adatti, si possono rimuovere i punti metallici).

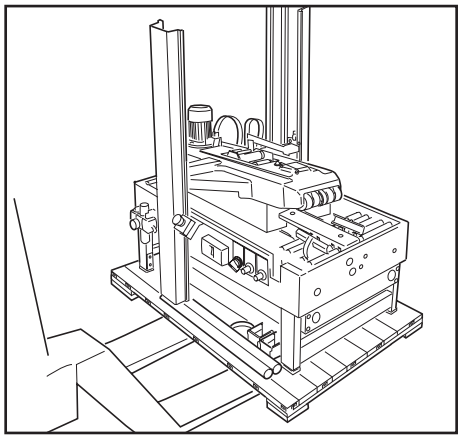


Dopo aver tagliato il cartone (o dopo la rimozione dei punti metallici), sollevare completamente il cartone in modo da liberare la macchina. (2 persone*)*

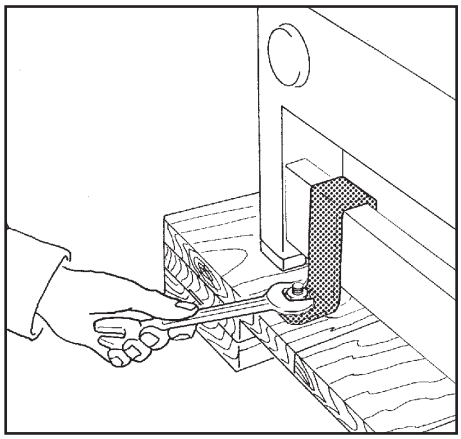


6-DISIMBALLO

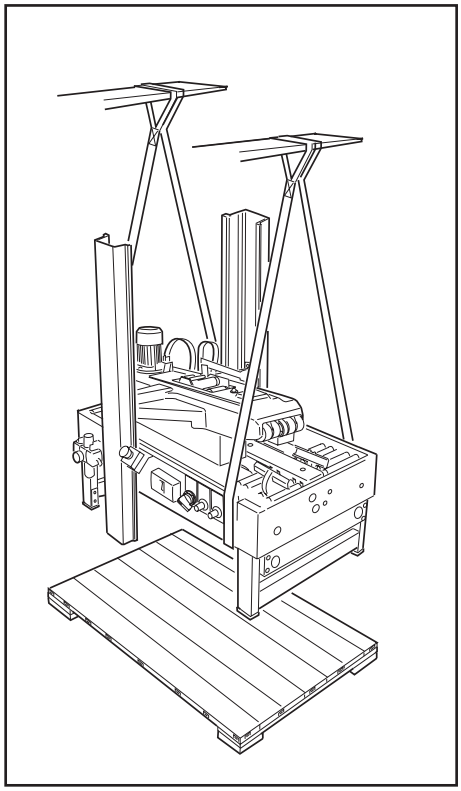
Trasportare la macchina con un muletto o un traspallet fino al punto in cui essa sarà collocata.
(Peso macchina + bancale = kg. 185).



Allentare i dadi e rimuovere, con la chiave in dotazione, le squadrette di bloccaggio che fissano la macchina al bancale.



Sollevare la macchina come illustrato (peso della macchina 165 kg) e rimuovere il bancale in legno.



6.2 SMALTIMENTO DELL'IMBALLO

L'imballo della macchina Mod. SR46-S è composto da:
-bancale in legno;
-cassa in cartone;
-staffe di fissaggio in acciaio;
-protezione in polietilene espanso;
-regge in plastica (PP);
-sali disidratanti in argilla (solo via mare);
-sacco in materiale accoppiato composto d a poliestere-alluminio-polietilene (solo via mare).

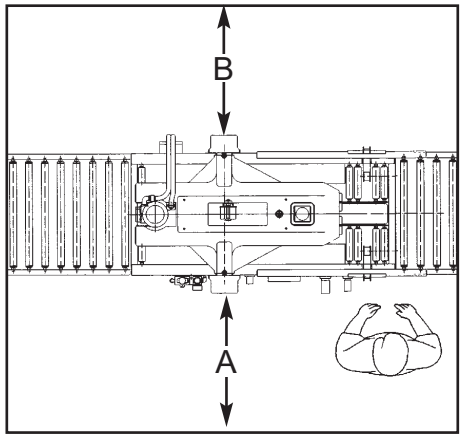
Per lo smaltimento comportarsi secondo le norme vigenti nel proprio paese.

7-INSTALLAZIONE

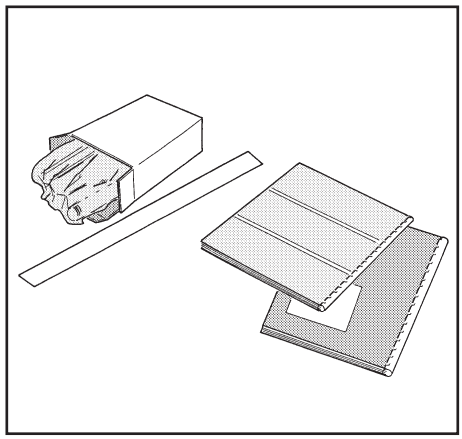
7.0. SICUREZZA
(Leggere attentamente il Capitolo 3).

7.1. CONDIZIONI AMBIENTALI
-Temperatura min. = 5 °C; max. 40 °C
-Umidità min 30%; max. 80%
-Ambiente esente da polvere.

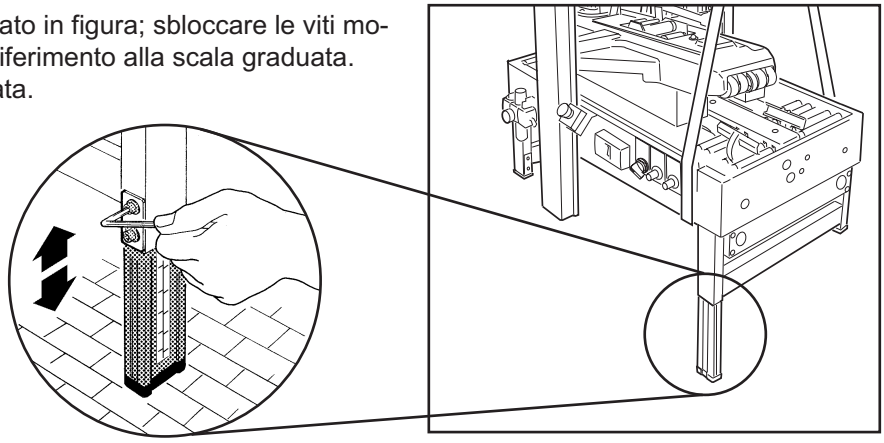
7.2. SPAZIO NECESSARIO PER L'USO E LA MANUTENZIONE
Distanza dal muro min. **A** = **1000** mm; **B** = **700** mm
Altezza min.= **2500** mm

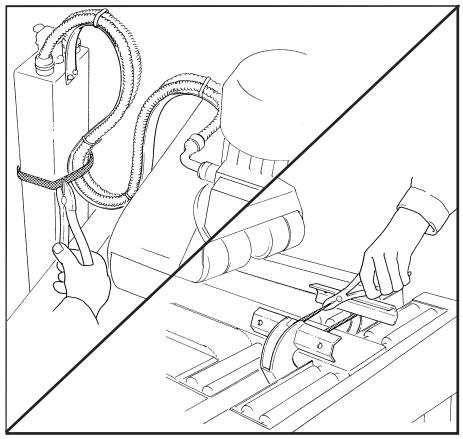


7.3 SET RICAMBI E TIRANASTRO PER UNITÁ NASTRANTI IN DOTAZIONE ALLA MACCHINA
Per la descrizione dettagliata vedere la sezione 13.1.



7.4 PIAZZAMENTO
Sollevare la macchina come illustrato in figura; sbloccare le viti mostrate e sfilare le gambe facendo riferimento alla scala graduata. Bloccare le viti all'altezza desiderata.

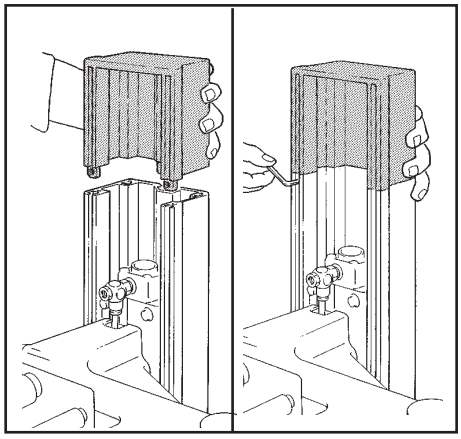




7.5 RIMOZIONE DEI BLOCCHI
Tagliare la fascetta che blocca la bandella alla canalina con i cavi di alimentazione motore e stop emergenza e la fascetta che blocca le leve del centratore.

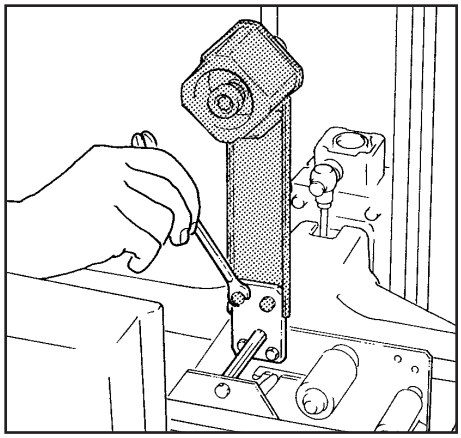
7.6 POSIZIONAMENTO PROTEZIONI COLONNE

Recuperare le protezioni colonne e montarle come illustrato in figura.



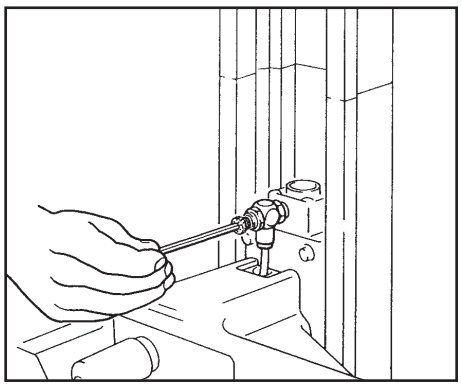
7.7. POSIZIONAMENTO PORTAROTOLO UNITA' SUPERIORE

Rimuovere le viti che fissano il portarotolo alla macchina: posizionarlo come illustrato in figura e bloccarlo con le viti precedentemente tolte.

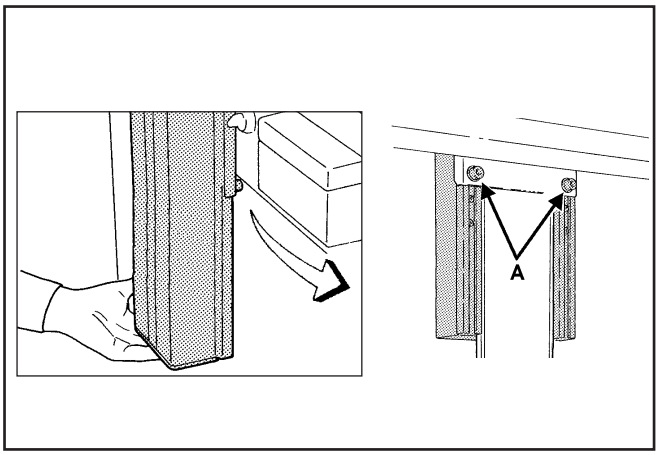


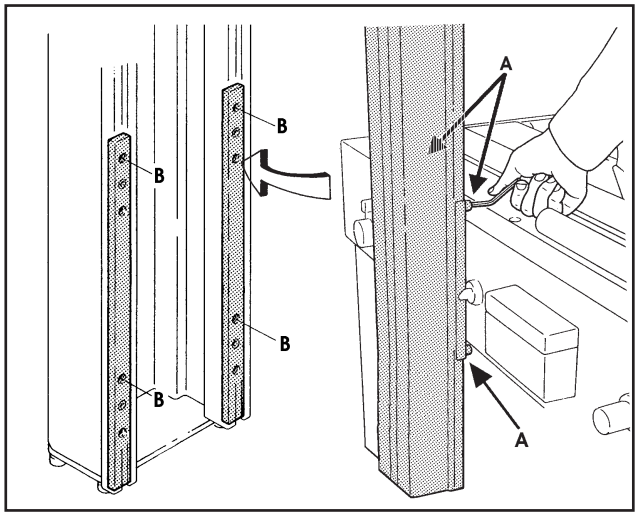
7.8 POSIZIONAMENTO COLONNE

Allentare il tappo del cilindro pneumatico.



Tenere con una mano la colonna e rimuovere le due viti **A**.
Spingere verso l'alto la colonna fino a posizionarla in corrispondenza dei fori **B**.
Recuperare le altre due viti inserite nei pezzi di ricambio e fissare la colonna (quattro viti per colonna).

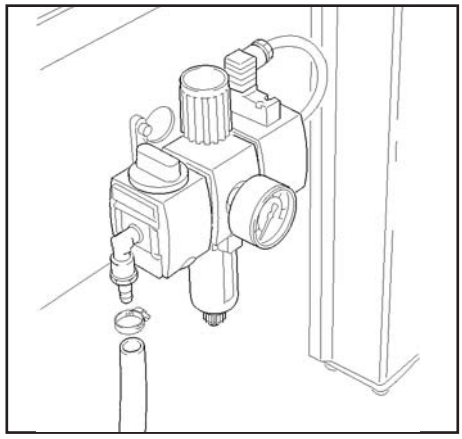




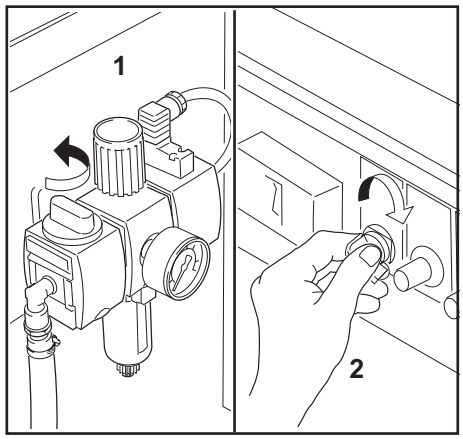
7-INSTALLAZIONE

7.9 COLLEGAMENTO PNEUMATICO

Collegare un tubo da 8 mm al raccordo e fissarlo con la fascetta fornita in dotazione.

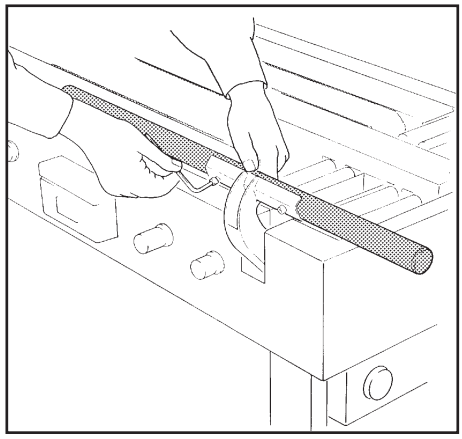


Attivare l'impianto pneumatico agendo sulla manopola **1** ed alzare la testata superiore agendo sul selettore **2**. Rimuovere i blocchi di polistirolo utilizzati per il trasporto.



7.10 POSIZIONAMENTO GUIDE SCATOLE

Montare le guide scatola sulle leve del centratore come illustrato nella Tavola.



7.11 CONTROLLLI ELETTRICI PRELIMINARI

Prima di collegare la macchina alla presa di corrente compiere i seguenti controlli:

7.11.1 Accertarsi che la presa sia munita di un circuito di protezione di terra e che la tensione e la frequenza di alimentazione corrispondano a quelle riportate sulla targhetta della macchina.

7.11.2 E' responsabilità dell'utilizzatore accertare che il collegamento della macchina alla rete rispetti le norme in vigore nel luogo di installazione.

7.11.3 La macchina è dotata di interruttore generale con potere di interruzione di 6 kA e sganciatore di corto circuito che interviene a 120 A. E' responsabilità dell'utilizzatore controllare la corrente di corto circuito del suo impianto e verificare che l'intensità di corrente prevista ai morsetti dell'interruttore generale sia compatibile con l'impianto stesso.

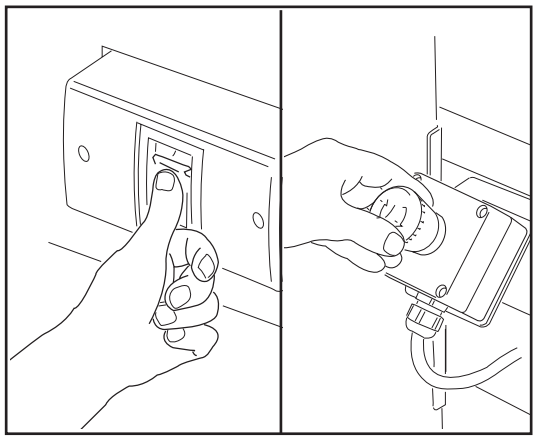
7.12 ALLACCIAMENTO ALLE FONTI DI ENERGIA E RELATIVI CONTROLLI

Potenza installata = kW 0,240.
Potere di interruzione dell'interruttore generale = 6 kA (230/240 V).
Per le caratteristiche tecniche dell'interruttore generale: vedere sezione **15- ALLEGATI.**

-Premere il tasto STOP EMERGENZA a ritenuta.
-L'interruttore principale magneto-termico è normalmente sulla posizione OFF.
-Collegare al cavo fornito con la macchina, una spina conforme alla normativa del paese dell'utilizzatore

7.13 CONTROLLO DELLE FASI (PER ALIMENTAZIONE TRIFASE)

Procedura da seguire per il corretto collegamento dell'ordine delle fasi:



-Rimuovere eventuali attrezzi appoggiati sulla macchina.

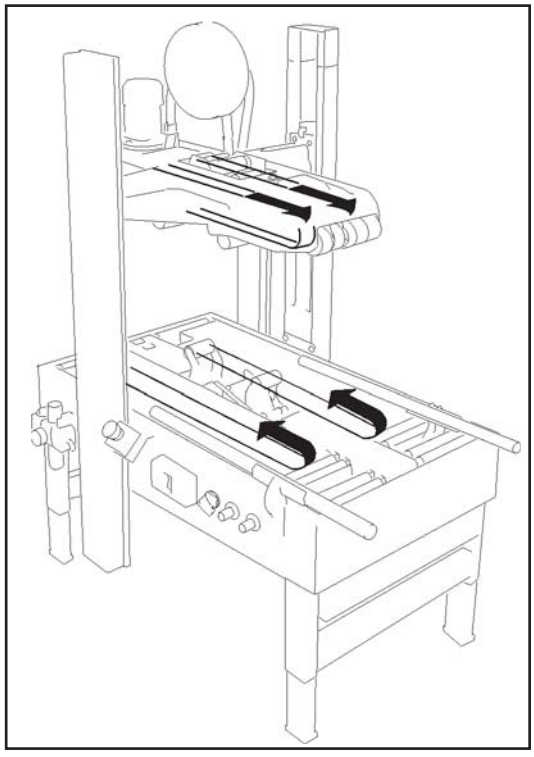
-Sbloccare il pulsante stop di emergenza a ritenuta, girandolo in senso orario.

-Premere il tasto ON sull'interruttore principale.

-Controllare, prima di usare la macchina, il senso di rotazione delle cinghie di trascinamento.

-Nel caso girassero nel senso contrario, invertire due fasi sui morsetti della spina di collegamento.

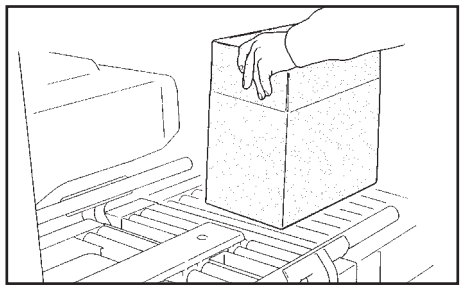
Senso di rotazione delle cinghie di trascinamento.



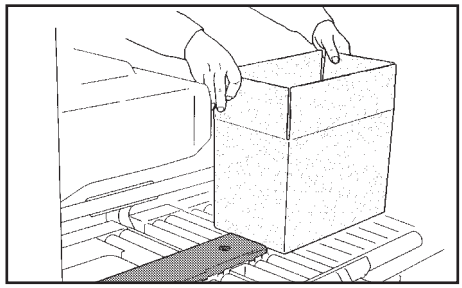
8-FUNZIONAMENTO

8.1 DESCRIZIONE DEL FUNZIONAMENTO

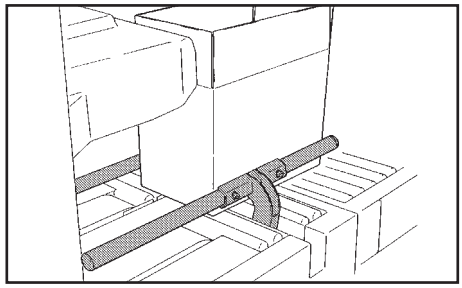
Ripiegare manualmente le quattro falde inferiori della scatola ed appoggiare la scatola con le falde inferiori ripiegate sulla rulliera.



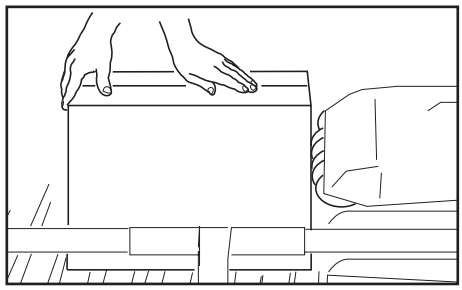
Tenendo la scatola con le due mani farla avanzare fino a premere la valvola a leva questa avvicinerà le guide laterali alla scatola.



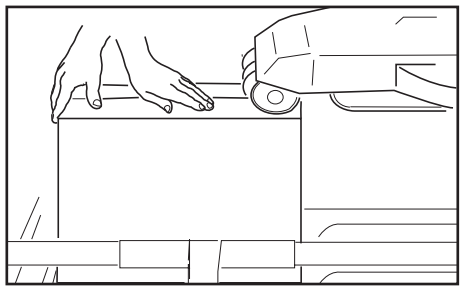
Le guide laterali bloccano la scatola sul centratore permettendo così di riempirla senza tenerla con le mani.



A riempimento avvenuto ripiegare le falde superiori e spingere la scatola contro la leva che comanderà la salita della testata.



Spingere la scatola nella macchina fino a sovrastare le cinghie di trascinamento inferiori.



8.2 DESCRIZIONE DEI MODI DI MARCIA

La nastratrice Mod. SR46-S lavora solo in modo automatico:

- pulsante STOP EMERGENZA non ritenuto;
- pulsante marcia inserito ON.
- impianto pneumatico attivato.

8.3 DESCRIZIONE DEI MODI DI ARRESTO

8.3.1 ARRESTO NORMALE

L'arresto della macchina è immediato in qualsiasi punto del ciclo commutando su OFF l'interruttore generale.
Vale la stessa cosa in caso di interruzione dell'alimentazione di rete.
L'impianto pneumatico rimane attivato.

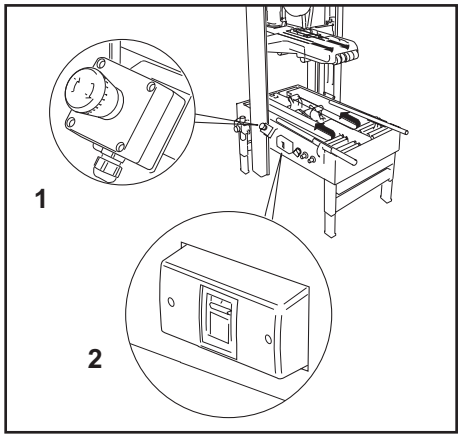
8.3.2 ARRESTO DI EMERGENZA

Pulsante a fungo per l'arresto di emergenza a ritenuta.
(Componente a bordo macchina non fabbricato dal costruttore. Per le caratteristiche tecniche vedere la sezione **15-ALLEGAT**I)

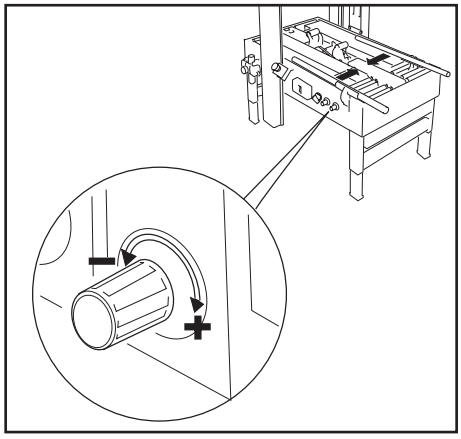
9-COMANDI IN BREVE

9.1 PULSANTE DI MARCIA/ARRESTO (2)
Mette in movimento/arresta le cinghie trascinamento scatola.

TASTO STOP DI EMERGENZA (1)
Arresta il ciclo della macchina.

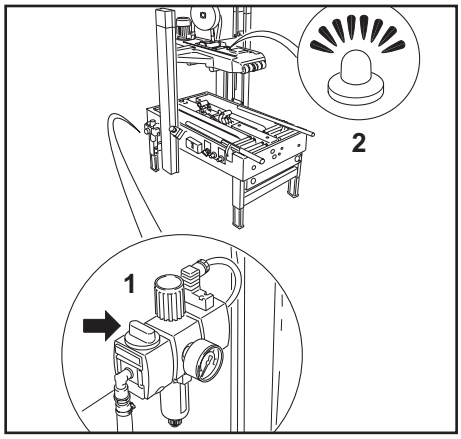


9.2 MANOPOLA REGOLAZIONE PRESSIONE GUIDE
Regola la pressione delle guide scatola sulla scatola.

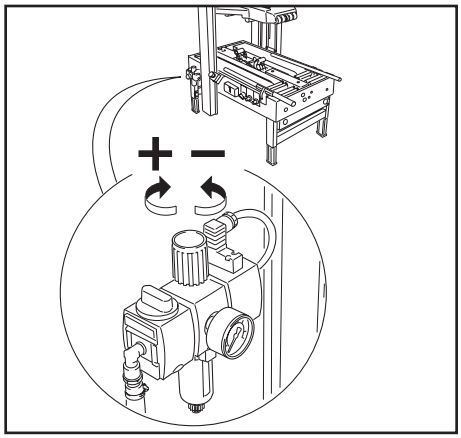


9.3 VALVOLA ALIMENTAZIONE IMPIANTO PNEUMATICO (1)
Attiva / disattiva l'impianto pneumatico

SPIA PRESSIONE ARIA (2)
Indica la presenza dell'aria nel circuito (indicatore rosso visibile).



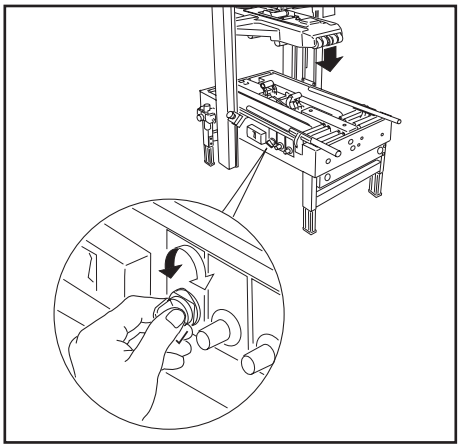
9.4 MANOPOLA REGOLAZIONE PRESSIONE IMPIANTO PNEUMATICO
Aumenta / diminuisce la pressione nel circuito.



9-COMANDI IN BREVE

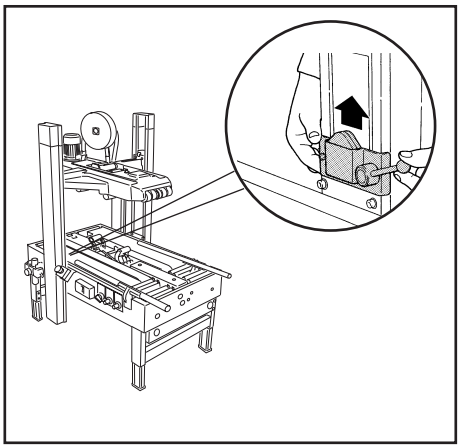
9.5 SELETTORE SALITA / DISCESA TESTATA

Fa salire / scendere la testata superiore.



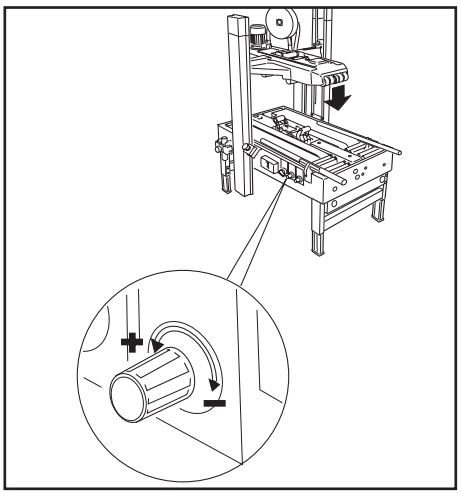
9.6 BLOCCO ALTEZZA TESTATA

Serve a posizionare la testata superiore in funzione delle scatole più basse.



9.7 MANOPOLA REGOLAZIONE PRESSIONE TESTATA

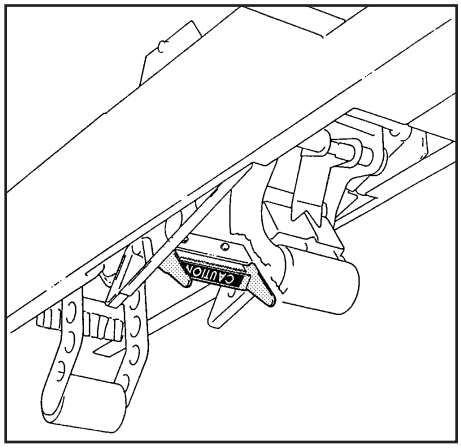
Aumenta/diminuisce la pressione della testata (discesa sulla scatola)



10-DESCRIZIONE DEI SISTEMI DI SICUREZZA DELLA MACCHINA

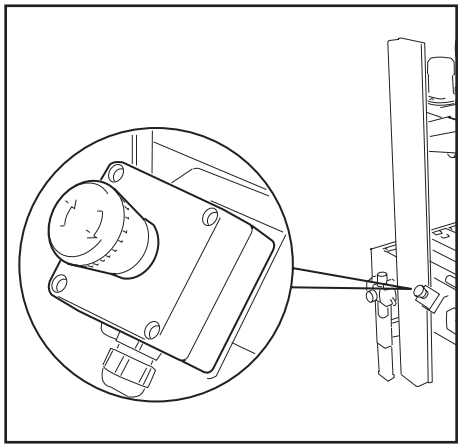
10.1 PROTEZIONI LAME

La lama di entrambe le unità nastranti è protetta da un dispositivo a molla.



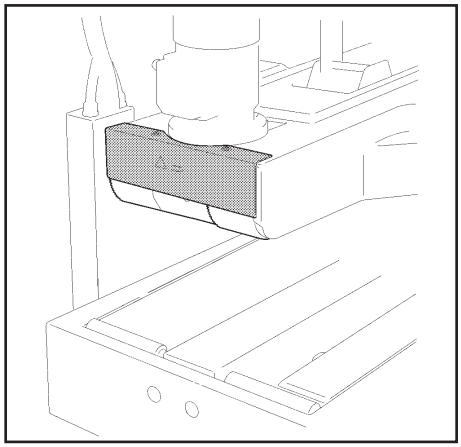
10.2 STOP DI EMERGENZA

Il pulsante di emergenza a ritenuta è collocato in posizione facilmente raggiungibile.



10.3 PROTEZIONE IN METALLO

Protezione cinghie di trascinamento superiori.



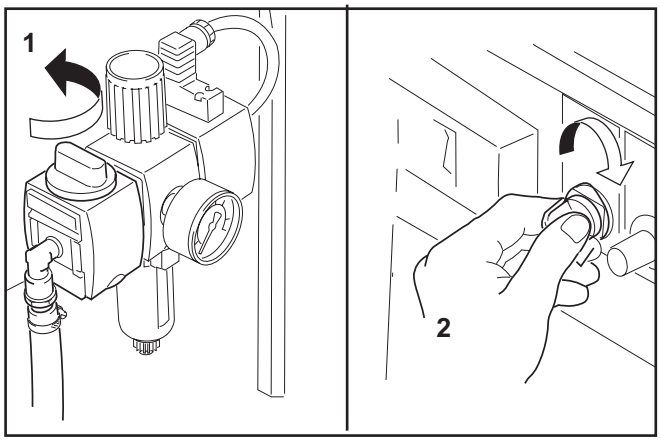
10.4 IMPIANTO ELETTRICO

L'impianto elettrico è protetto da un filo di terra, la cui continuità è oggetto di prova e collaudo finale, insieme alla prova di isolamento e di rigidità dielettrica dell'impianto.
(Vedi sezione **ALLEGATI 15.5**)

11-PREPARAZIONE ALL'USO E REGOLAZIONI

11.0 SICUREZZA

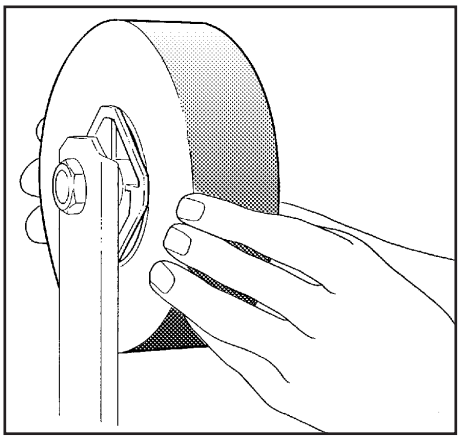
Tutte le operazioni di preparazione e di regolazione devono essere effettuate con macchina ferma e pulsante STOP EMERGENZA ritenuto.



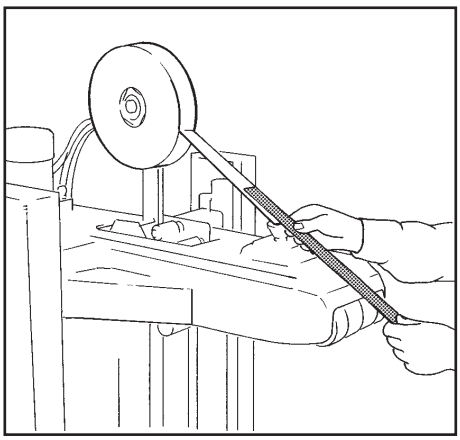
11.1 MONTAGGIO DEL NASTRO NELL'UNITÀ NASTRANTE SUPERIORE

Attivare l'impianto pneumatico ruotando in senso antiorario la manopola **1** ed alzare la testata superiore ruotando in senso orario il selettore **2**.

Posizionare una bobina di nastro sul portarotolo avendo cura di spingere la bobina fino in fondo al portarotolo.

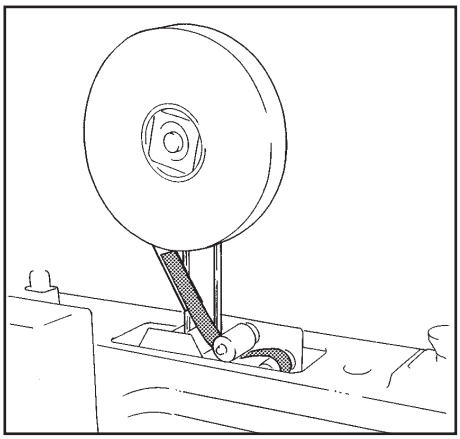


Incollare il nastro all'apposito attrezzo tiranastro.

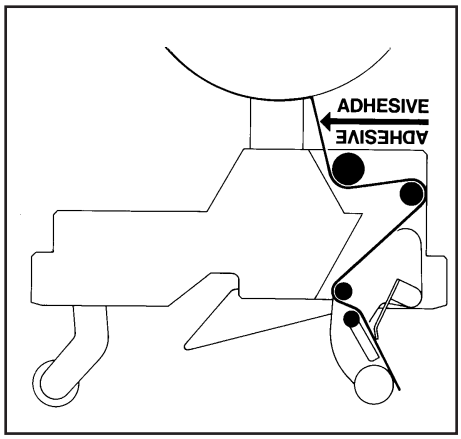


ATTENZIONE! Lama molto affilata, può causare severe ferite.

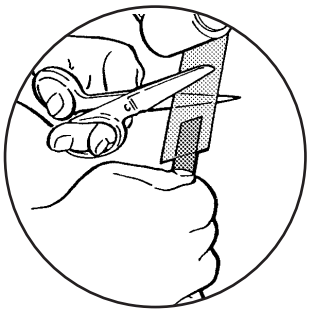
Inserire il tiranastro nell'unità nastrante, facendo molta attenzione a tenere le mani fuori dalla portata delle lame taglia-nastro **(Vedi punto 3.11-g).**

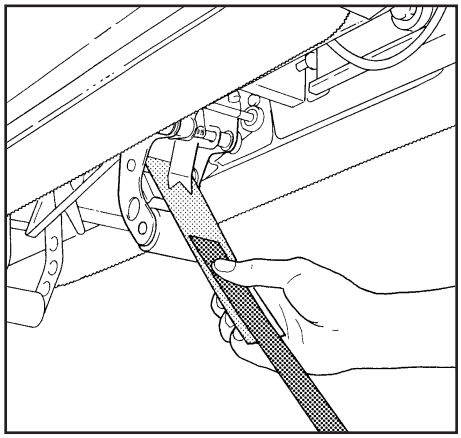


Far percorrere al nastro il tratto indicato nella figura curando che il lato adesivo si trovi sul lato indicato dalla freccia.



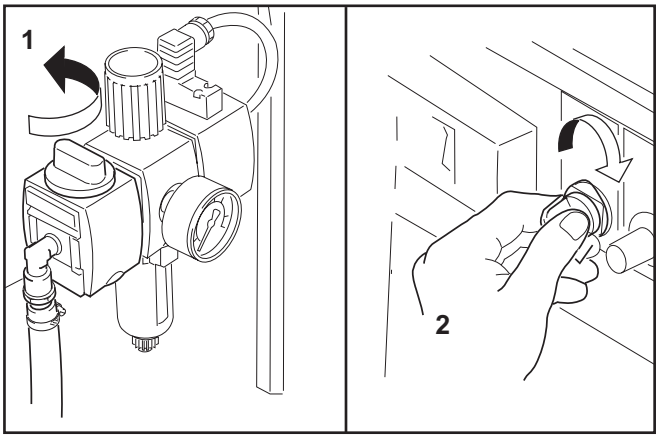
Tirare e tagliare il nastro in eccedenza.



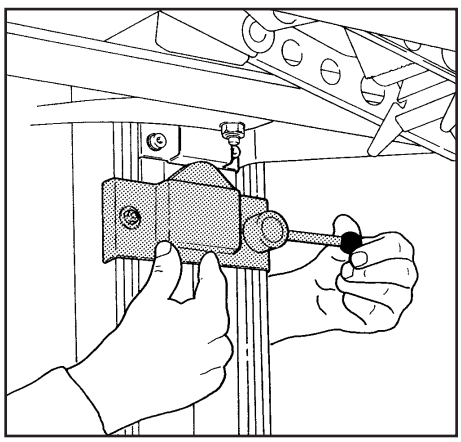


11.2 MONTAGGIO DEL NASTRO NELL'UNITÀ NASTRANTE INFERIORE

Attivare l'impianto pneumatico ruotando in senso antiorario la manopola **1** ed alzare la testata superiore ruotando in senso orario il selettore **2.**

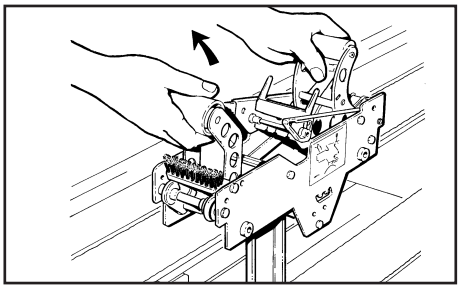


Alzare il fermo contro la testata superiore e bloccarlo con la leva.
A sostituzione nastro avvenuta, riportare il fermo in posizione originale.

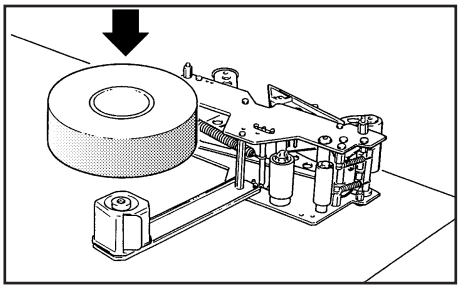


11-PREPARAZIONE ALL'USO E REGOLAZIONI

Sfilare l'unità nastrante dal proprio alloggiamento ed appoggiarla su un piano di lavoro.

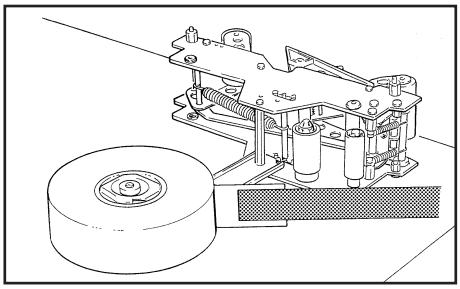


Posizionare una bobina di nastro sul portarotolo.

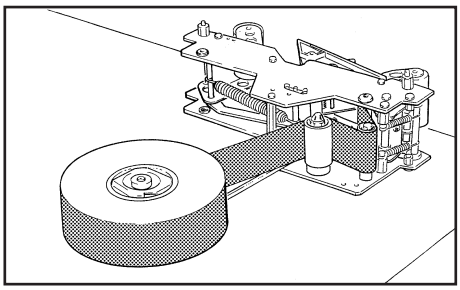


ATTENZIONE! Lama molto affilata, può causare serie ferite.

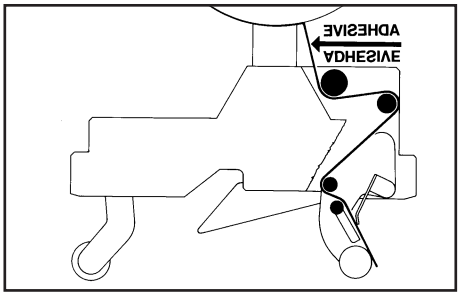
Incollare il nastro al tiranastro.



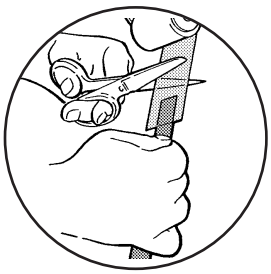
Inserire il tiranastro nell'unità nastrante facendo molta attenzione a tenere le mani fuori dalla portata delle lame taglianastro (Vedere punto 3.11-g).



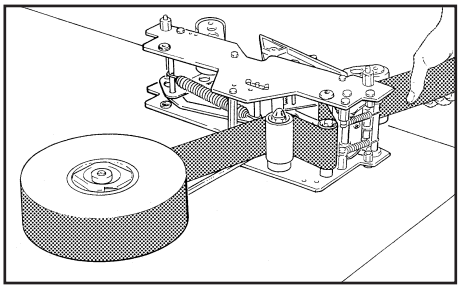
Fare percorrere al nastro il tratto indicato in figure curando che il lato adesivo si trovi sul lato indicato dalla freccia.



Tirare e tagliare il nastro in eccedenza



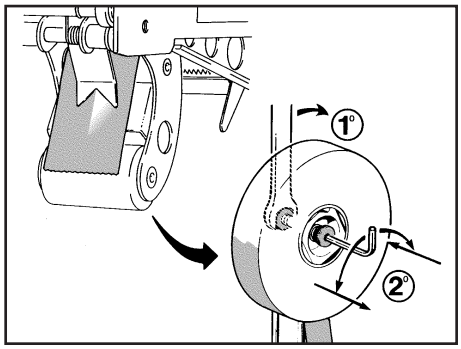
Reinserire l'unità nastrante nel suo alloggiamento.



11-PREPARAZIONE ALL'USO E REGOLAZIONI

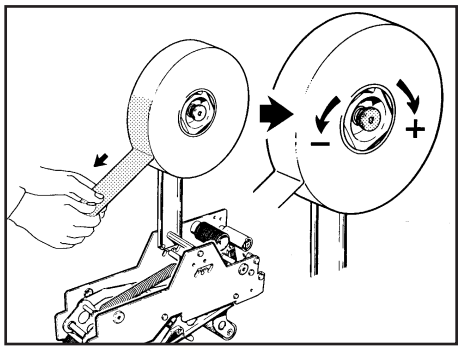
11.3 REGOLAZIONE DEL PORTAROTOLO

Verificare la centratura del nastro sui rulli dell'unità.
Se necessario, sbloccare il dado **1** e registrare la vite **2**.



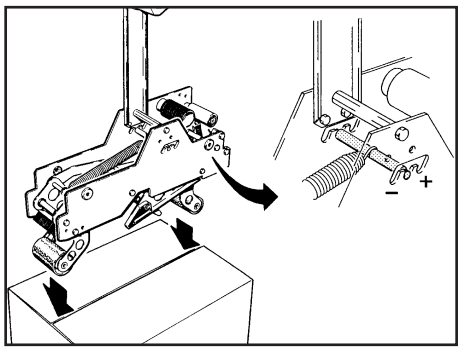
11.4 REGOLAZIONE DELLA FRIZIONE DEL NASTRO

Verificare la tensione del nastro:
- portarotolo libero per nastro in PVC
- portarotololeggermente frizionato per nastro in OPP



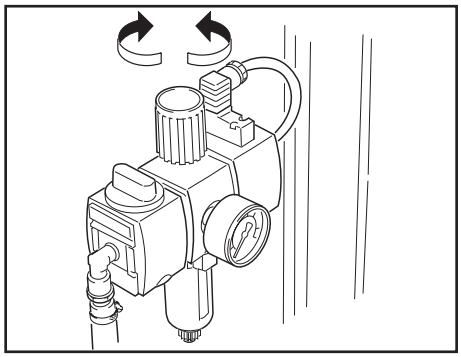
11.5 REGOLAZIONE DELLE UNITÀ NASTRANTI PER IL TIPO DI SCATOLE

Regolare la molla principale:
- su scatole leggere dare meno carico alla molla;
- su scatole robuste dare più carico alla molla.



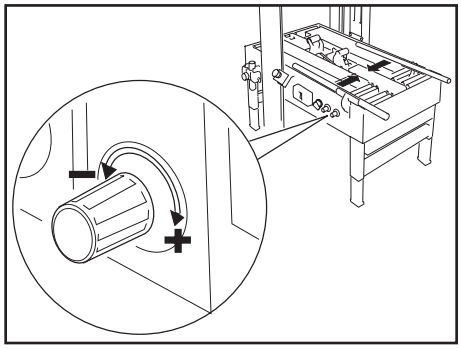
11.6 REGOLATORE DI PRESSIONE

Regolare la pressione dell'aria in funzione dello spessore del cartone.
Pressione max. **6 Bar**.



11.7 REGOLAZIONE PRESSIONE GUIDE

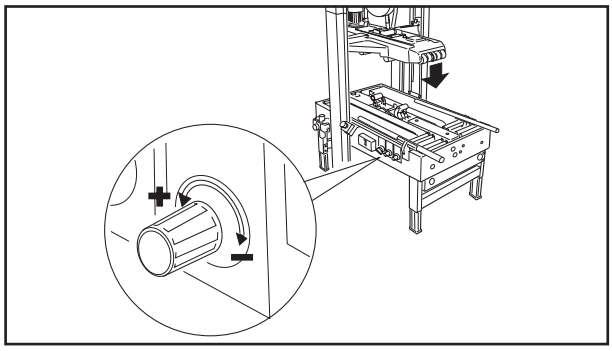
Regolare la pressione delle guide laterali sulle scatole.
Diminuire per cartoni leggeri; aumentare per cartoni pesanti.



11.8 REGOLAZIONE PRESSIONE TESTATA SUPERIORE

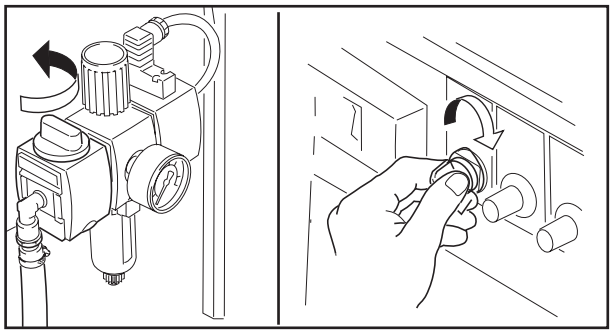
Regolare la pressione della testata superiore sulla scatola.

Diminuire per cartoni parzialmente vuoti o leggeri; aumentare dove richiesta una maggior pressione sul cartone.

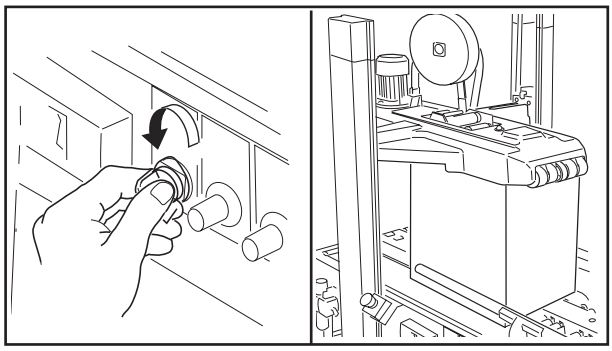


11.9 REGOLAZIONE DISCESA TESTATA SUPERIORE (VELOCIZZAZIONE PRODUZIONE)

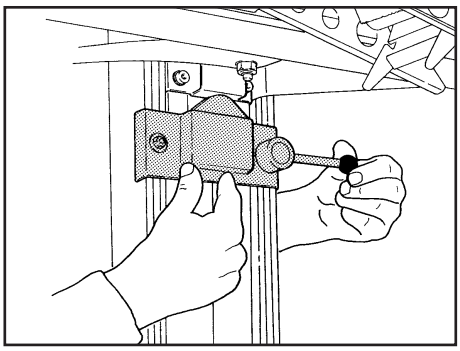
In condizioni normali la testata superiore scende fino all'altezza minima di 110 mm dopo ogni ciclo di nastratura.
É possibile limitare la discesa della testata superiore quando:
a) si chiudono scatole di varie misure e si conosce l'altezza minima tra tali diverse misure.
b) si chiudono lotti di scatole di misura uniforme e si vuole accelerare la produzione di ciascun lotto.
Per regolare l'altezza minima della testata procedere come segue:



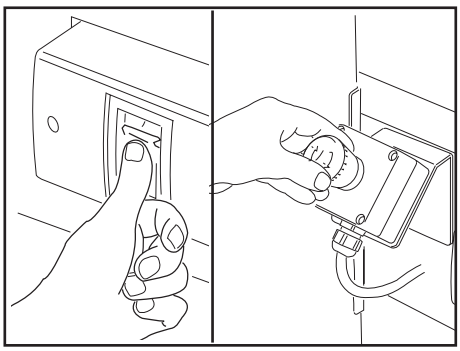
Ruotare il selettore in senso orario per alzare la testata. Inserire la scatola da nastrare e ruotare il selettore in senso antiorario facendo scendere la testata fino a quando non si appoggi sulla scatola.



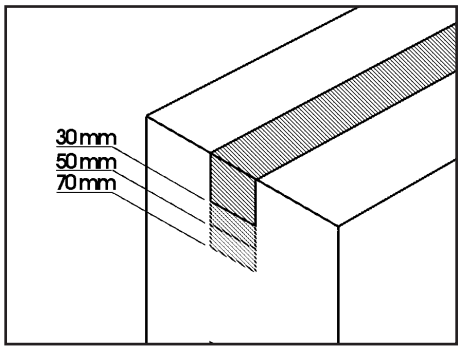
Portare il fermo contro la testata superiore e bloccarlo con la relativa maniglia.



Ruotare il pulsante STOP EMERGENZA in senso orario e premere il tasto ON.
La scatola verrà trascinata dalle cinghie superiori e inferiori, nastrata e quindi espulsa dalla macchina.



REGOLAZIONI SPECIALI



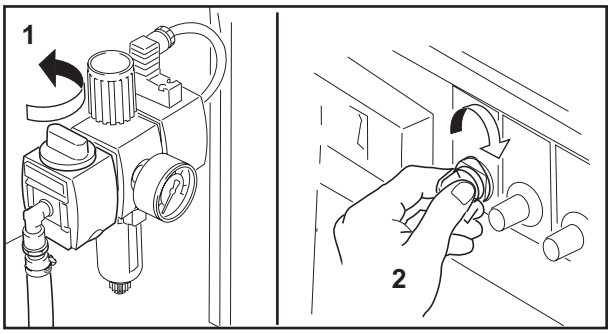
11.10 MODIFICA LUNGHEZZA LEMBO NASTRO

La lunghezza del lembo nastro può variare da 70 a 50 a 30 mm.
Per questo tipo di regolazione, fare riferimento al manuale dell'unità nastrante K12, fornito con la macchina.

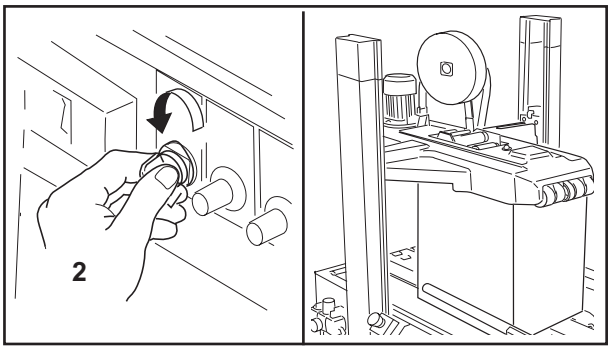
COLONNE FISSE IN POSIZIONE ALTA

Per potere nastrare scatole aventi altezza superiore a 750 mm e fino a 930 mm (vedere pag. **23**) é necessario alzare le colonne della macchina. Procedere come segue:

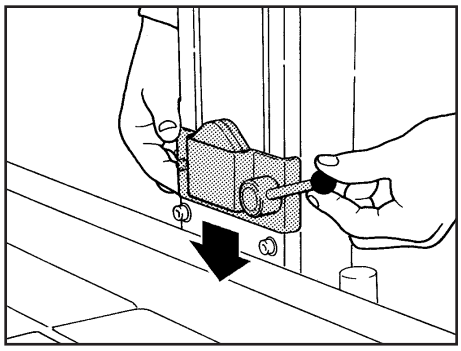
attivare l'impianto pneumatico ruotando in senso antiorario la manopola 1 ed alzare la testata superiore ruotando in senso orario il selettore **2**.



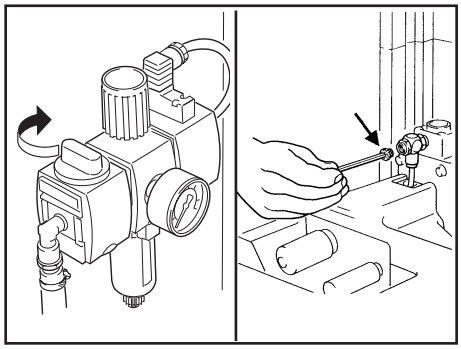
Inserire sotto la testata una cassa (altezza 450 mm circa) sufficientemente rigida da sopportare il peso della testata (45 kg).
Ruotare il selettore **2** in senso antiorario facendo scendere la testata fino ad appoggiarla sul supporto.



Sbloccare e abbassare completamente il fermo.

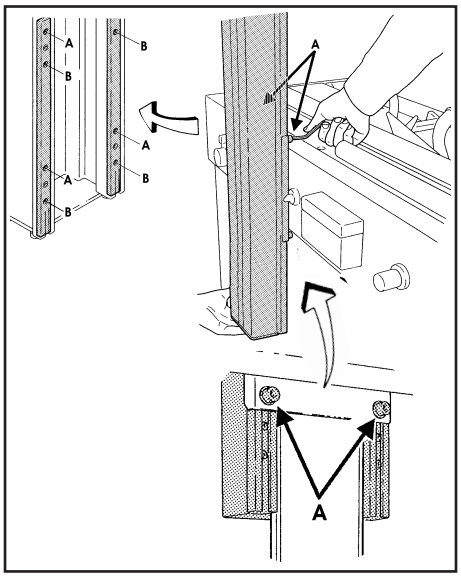


Disattivare l'impianto pneumatico ruotando la manopola in senso orario.
Togliere il tappo in modo di far fuoriuscire tutta l'aria dall'impianto pneumatico.
Riavvitare il tappo.



Tenere con una mano la colonna e rimuovere le quattro viti **A** con l'altra mano; spingere verso l'alto la colonna fino a raggiungere i fori **B**.

Rimontare le viti. Riattivare l'impianto pneumatico.

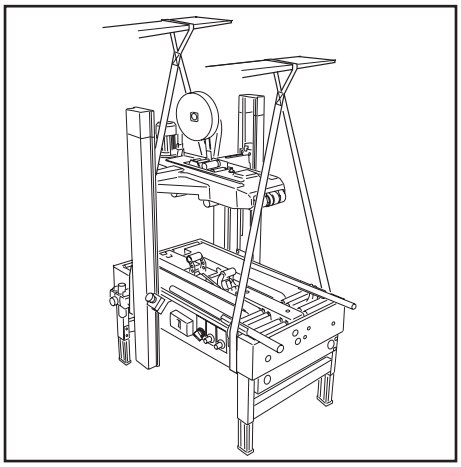


ACCESSORI OPZIONALI

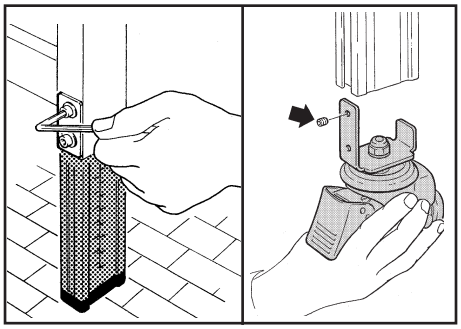
11.12 SET RUOTE OPZIONALI (AS77)
(Codice set: 7.8.04337.00B)

Per agevolare lo spostamento della macchina é possibile montare quattro ruote; di conseguenza variano l'altezza del piano rulliere e le dimensioni generali (vedere il parag. 4.7*).*

Sollevare la macchina come illustrato in figura.



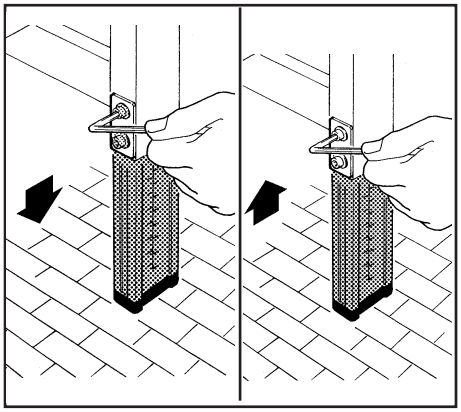
Togliere i piedini, infilare le ruote, fissarle con i due grani e ripristinare l'altezza piano rulliere facendo riferimento alla scala graduata.
(Altezza ruota = 100 mm*).*



11.13 SET GAMBE OPZIONALI H=600 (AS80)
(Codice set: 7.8.04413.00A)

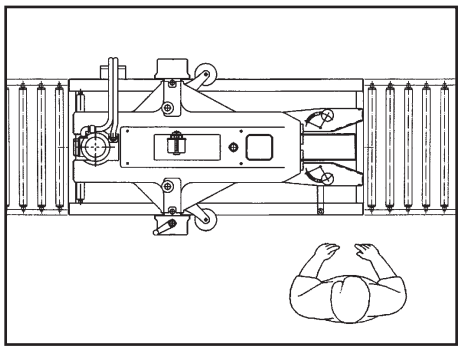
Per poter alzare il piano rulliere, come riportato al paragrafo 4.7, é necessario sostituire le gambe.

Sollevare la macchina come indicato in figura.
Sbloccare le viti e sfilare le gambe.
Infilare le gambe nuove e bloccarle facendo riferimento alla scala graduata.



12-USO DELLA MACCHINA

12.1 POSIZIONE CORRETTA DELL'OPERATORE



12.2 MESSA IN MARCIA

Premere ON sull'interruttore principale.

12.3 AVVIO DELLA PRODUZIONE

Prima di iniziare la produzione far funzionare la macchina a vuoto e provare le sicurezze (vedi paragrafo 12.8).
Poi iniziare il ciclo di lavoro.

12.4 SOSTITUZIONE NASTRO

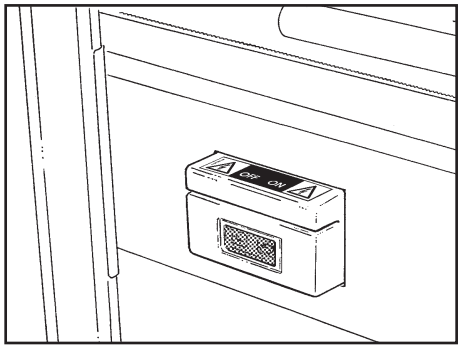
Prestare particolare attenzione alle lame.

Qualifica op. 1

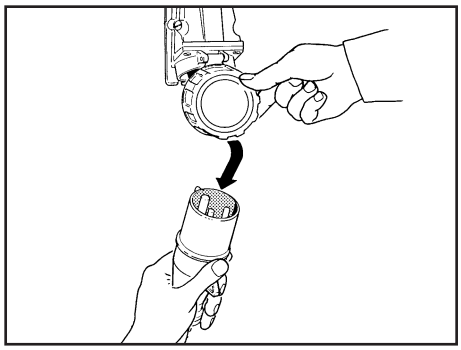
Ogni volta si renda necessario sostituire la bobina di nastro, agire nel seguente modo:
-Premere il pulsante STOP EMERGENZA a ritenuta;
-Ripetere tutte le operazioni mostrate ai punti 11.1 e/o 11.2

12.5 PULIZIA

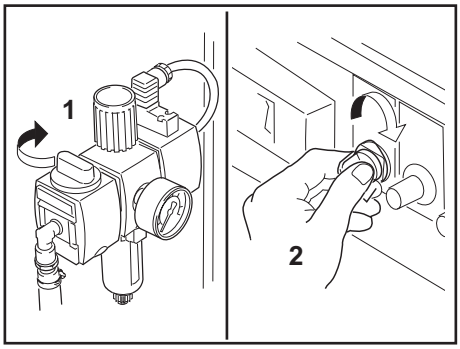
Prima di ogni operazione di pulizia o manutenzione fermare la macchina premendo il tasto sull'interruttore principale.



Staccare la spina dal quadro di alimentazione



Attivare l'impianto pneumatico ruotando in senso antiorario la manopola **1** ed alzare la testata superiore ruotando in senso orario il selettore **2**.
Bloccare la testata con il perno (vedere parag. 11.2).



PULIZIA - Qualifica operatore **1**
Utilizzare panni asciutti o blande soluzioni detergenti.

É vietato utilizzare solventi e getti d'acqua.

12.6 TAVOLA RIASSUNTIVA DELLE REGOLAZIONI

OPERAZIONI	OPERATORE	CAPITOLI
Cambio nastro	**1**	**11.1 - 11.2**
Regolazione centratura nastro	**1**	**11.3**
Controllo delle sicurezze	**1**	**12.7**
Regolazione frizione nastro	**1**	**11.4**
Regolazione discesa testata superiore	**1**	**11.9**
Regolazione pressione applicazione nastro	**1**	**11.5**
Regolazione altezza da terra	**1**	**7.4**
Pressione aria	**1**	**9.3**
Regolazioni speciali: Lembo nastro	**2**	**11.10**
Regolazioni speciali: Colonne fisse in posizione alta	**2**	**11.11**

12.7 CONTROLLO EFFICIENZA SICUREZZE

1 Protezione lama unità nastranti (Parag. 10.1)
2 Pulsante d'emergenza a ritenuta (Parag. 10.2)
3 Pulsante STOP (OFF) su interruttore principale (Paragg. 7.11.3 e 9.1)

SITUAZIONE	CAUSA	RIMEDIO
Premendo il tasto ON il pulsante non rimane inserito e la macchina non parte.	Pulsante STOP EMERGENZA premuto. Corto circuito sull'impianto.	Disinserirlo girando il pomolo in senso orario. Controllare.
La protezione magnetotermica fa aprire l'interruttore generale	Motore stotto sforzo. Taratura troppo bassa della termica nell'interruttore principale.	Controllare che le cinghie di trascinamento non siano bloccate. Controllare che l'assorbimento di corrente riportato sulla targhetta dei motori non sia superiore al valore impostato sulla termica.
Il motore gira ma le cinghie di trascinamento si fermano.	Cinghie allentate. Pulegge motrici usurate.	Regolare la tensione. Controllare lo stato di usura degli anelli ed eventualmente sostituirli.
Le cinghie di trascinamento girano ma la scatola non viene trascinata.	Cinghie di trascinamento usurate.	Sostituirle.
La testata superiore non scende oppure scende troppo lentamente/velocemente.	Selettore salita/discesa non azionato. E'stata alterata la regolazione di fabbrica	Ruotare in senso antiorario. Regolare la pressione.

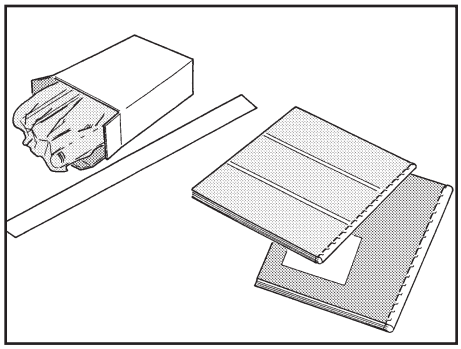
13- MANUTENZIONE E RIPARAZIONE

13.0 SICUREZZA

(Vedi punto 3)

Lo svolgimento di operazioni di manutenzione e riparazione comporta situazioni pericolose. Nella progettazione di questa macchina si è fatto specifico riferimento alle norme EN292 Nov. 92/6.1.2 ed EN292/2, Nov. 92/5.3.

13.1 ATTREZZI E RICAMBI IN DOTAZIONE ALLA MACCHINA



1 N.1 Lama (lama ricambio per unità nastrante, cod. S4004152ZZZ);
N. 1 Molla principale BOTTOM (cod. S370017992 Z);
N. 1 Molla principale TOP (cod. S370017894Z);
N. 2 Molla portalama (cod. S37022794Z);
2 Tiranastro (per inserire il nastro nelle unità, cod. S310091406Z);
3 Manuale della macchina (cod. SMB00049K)
4 Manuale dell'unità nastrante (cod. S300024296A0*).*

13.2 NATURA E FREQUENZA DI VERIFICHE ED INTERVENTI DI MANUTENZIONE

OPERAZIONI	FREQUENZA	QUAL. OPERATORE	CAPITOLO
Lubrificazioni	Trimestrale	**2**	**13.5-6-7**
Pulizia lama	Settimanale	**2**	**13.8**
Pulizia macchina	Settimanale	**1**	**12.5**
Controllo dispositivi di sicurezza	Giornaliera	**1**	**13.4**
Sostituzione lama	//	**2**	**13.9**
Sostituzione cinghie	//	**2**	**13.10**

13.3 VERIFICHE DA ESEGUIRE PRIMA E DOPO OGNI OPERAZIONE DI MANUTENZIONE.

Prima di ogni operazione di manutenzione premere il tasto OFF sull'interruttore principale e togliere la spina dal quadro generale.

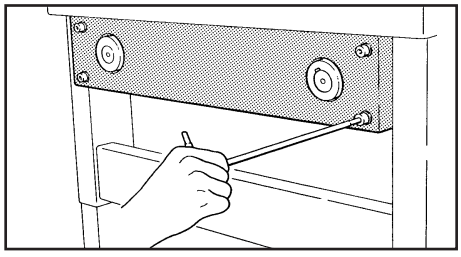
Durante la fase di manutenzione deve essere presente sulla macchina solo la persona addetta alla manutenzione stessa e nessun altro.

Al termine di ogni operazione di manutenzione controllare lo stato di funzionamento di tutte le sicurezze e delle protezioni antinfortunistiche.

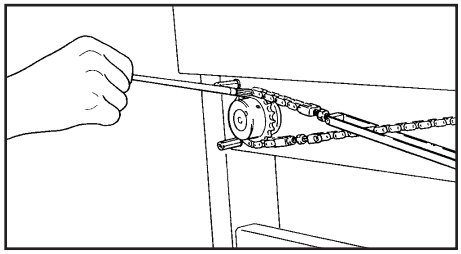
13.4 CONTROLLO EFFICIENZA SICUREZZE

1 Protezione lama unità nastranti (Parag. 10.1).
2 Pulsante d'emergenza a ritenuta (Parag. 10.1).
3 Pulsante STOP (OFF) su interruttore principale (Paragrafi 7.11.3 e 9.1)

13.5 LUBRIFICAZIONE DELLA MACCHINA



Togliere il coperchio



Lubrificare la catena ed i pignoni trimestralmente con grasso metallo/metallo.

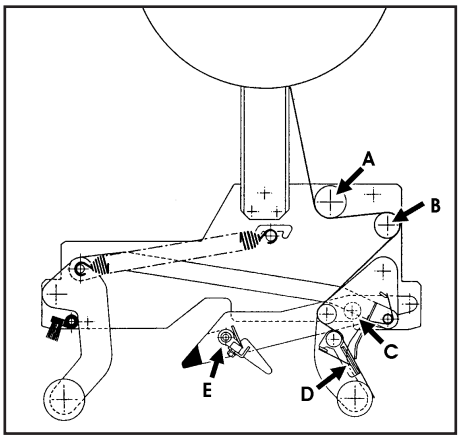
13.6 PRODOTTI PER LUBRIFICAZIONE

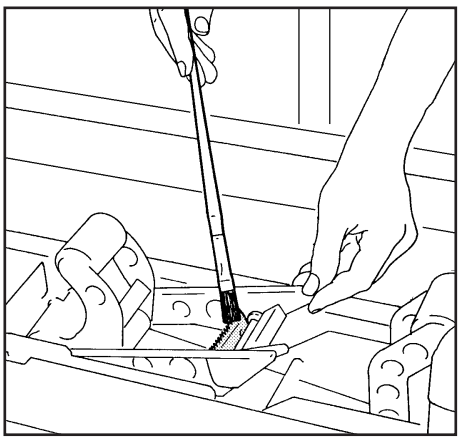
Grasso tipo:
METALLO/METALLO: B.C.190 HEAVY DUTY (oppure Grasso per catene o cuscinetti)
METALLO/PLASTICA: PLATE MASTER M+L (grasso al molibdeno e PTFE per materiali plastici e metallo)
Olio:
normale olio lubrificante oppure lubrificante idro repellente spray multiuso.

13.7 LUBRIFICAZIONE UNITÀ NASTRANTE

Lubrificare mensilmente con olio i punti indicati nella Tavola.

A perno attacco molla
B perno tendi molla
C perno rullo non ritorno
D cerniera portalama
E perno protezione lama





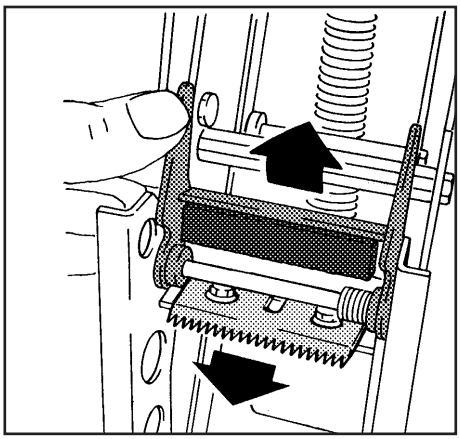
13.8 PULIZIA LAMA

Qualifica operatore **2**
Sollevare la protezione e pulire la lama con un pennello (con manico lungo) e olio. L'olio evita la formazione di accumuli di adesivo.

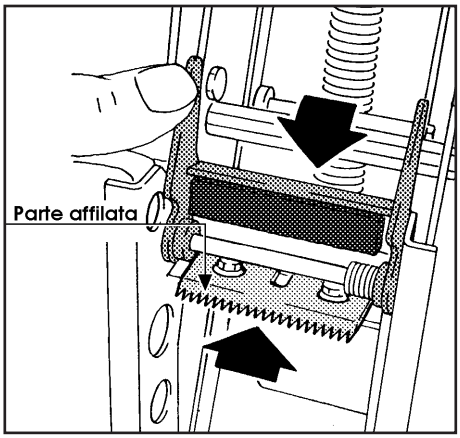
13.9 SOSTITUZIONE LAMA

Qualifica operatore **2**.
- Sollevare la protezione lama come illustrato nella Tavola
- Allentare le viti.
- Sfilare la lama.

ATTENZIONE!
La lama è molto affilata.
Errori durante questa operazione possono provocare severe ferite.

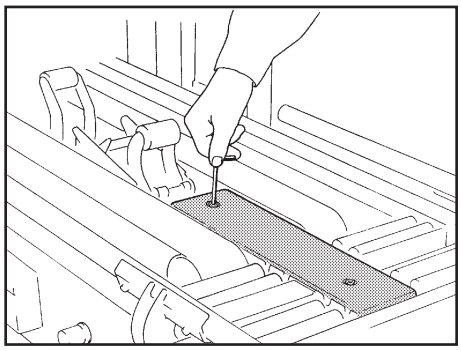


- Introdurre la nuova lama prestando attenzione all'esatta posizione dell'affilatura.
- Bloccare le viti.
- Rilasciare la protezione.

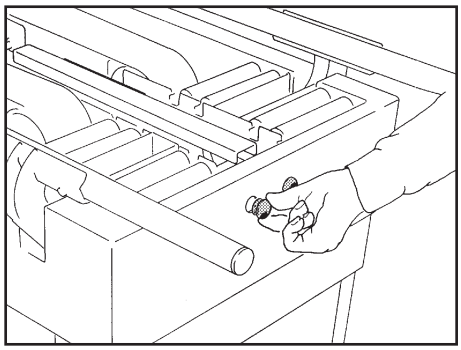


13.10 SOSTITUZIONE CINGHIE DI TRASCINAMENTO INFERIORI
Qualifica operatore **2**.

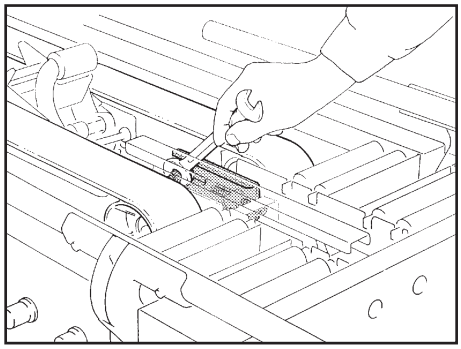
-Togliere le due viti.
-Rimuovere il carter



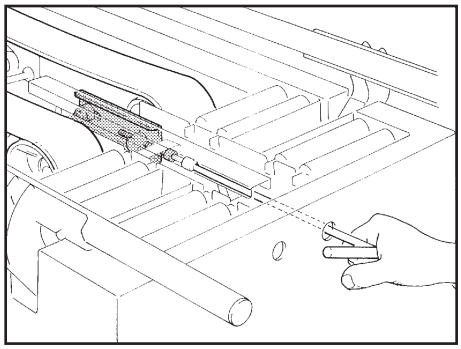
Togliere i due tappi.



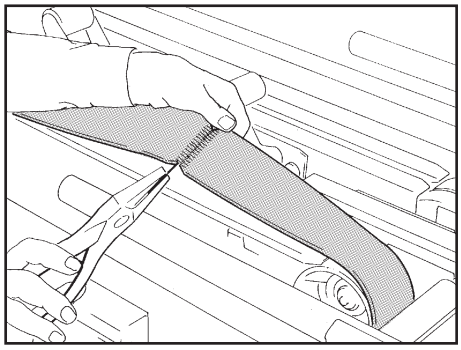
Allentare il dado di bloccaggio.



Allentare la vite di tensionamento.



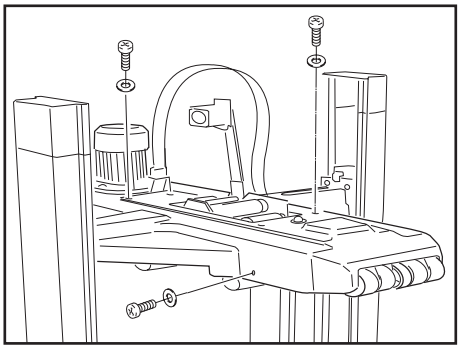
-Tagliare con un cutter la cinghia consumata.
-Posizionare la nuova cinghia.
-Inserire tra le maglie di giunzione un pernino di nylon.
-Regolare la tensione della cinghia.



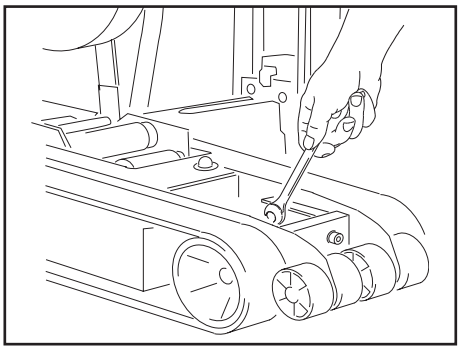
13.11 SOSTITUZIONE CINGHIE DI TRASCINAMENTO SUPERIORI

Qualifica operatore **2**

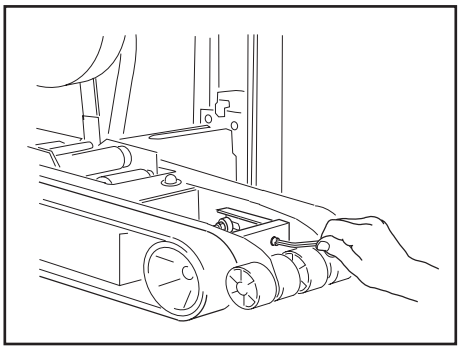
- Togliere le dieci viti che fissano il carter rimuoverlo.



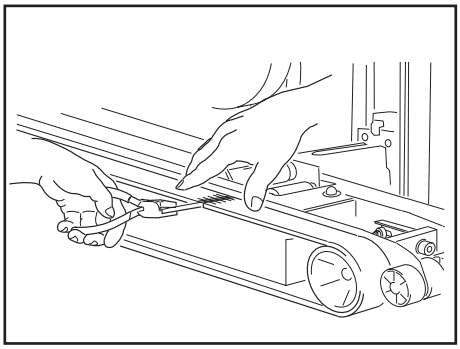
Allentare il dado di bloccaggio.



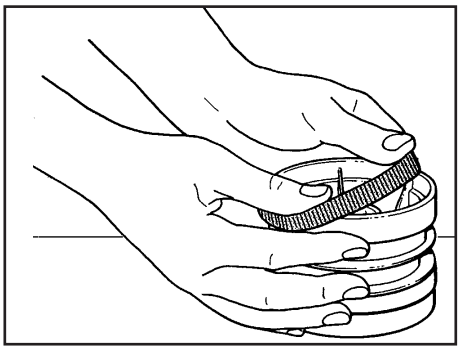
Allentare la vite di tensionamento.



- Tagliare con un cutter la cinghia consumata.
- Posizionare la nuova cinghia.
- Inserire tra le maglie di giunzione un pernino di nylon.
- Regolare la tensione della cinghia.

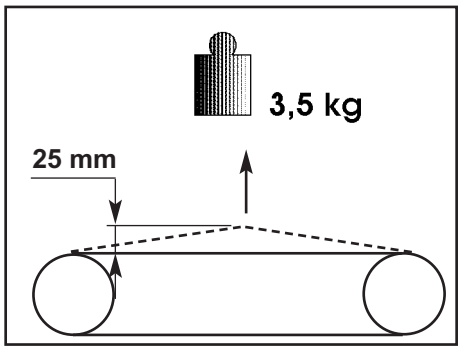


ATTENZIONE!
Prima di rimontare la nuova cinghia controllare la condizione degli anelli in plastica arancione sulle pulegge motrici: se usurati, sostituirli.

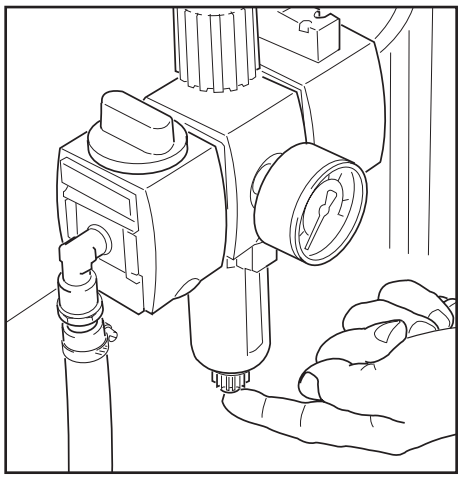


13.12 REGOLAZIONE TENSIONE CINGHIE

Controllare la tensione della cinghia sollevandola al centro; si deve staccare di circa 25 mm con una trazione di 3,5 kg.



IMPORTANTE!
Ogni qual volta si accumuli condensa nel filtro, rimuoverla effettuando una leggera pressione sulla parte inferiore del bicchierino come mostrato nella Tavola.



REGISTRO DEGLI INTERVENTI DI RIPARAZIONE EFFETTUATI SULLA MACCHINA

Data	Descrizione intervento

14- ISTRUZIONI SUPPLEMENTARI

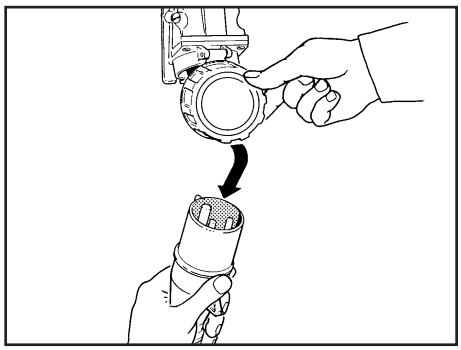
14.1 ISTRUZIONI PER LA ROTTAMAZIONE E L'ELIMINAZIONE

Materiali che compongono la macchina:
-Struttura in acciaio;
-Rullini di scorrimento in Nylon;
-Cinghie di trascinamento in PVC;
-Pulegge in Nylon.

Nel caso di smaltimento dei materiali che compongono la macchina: comportarsi secondo le norme vigenti nel proprio paese.

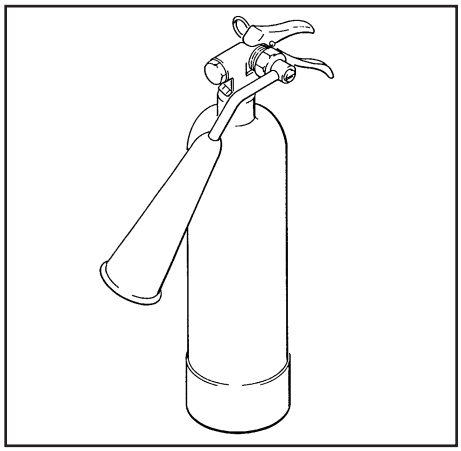
14.2 ISTRUZIONI PER SITUAZIONI DI EMERGENZA

In caso di pericolo/incendio:
staccare la spina dal quadro generale.



INCENDIO
In caso di incendio utilizzare estintore contenente CO2.

NON utilizzare acqua.



15- ALLEGATI

15.1 DICHIARAZIONE DI CONFORMITÀ

alla direttiva 98/37 CEE, 91/368, 93/44 e 93/68.

15.2 SEGNALETICA DI SICUREZZA

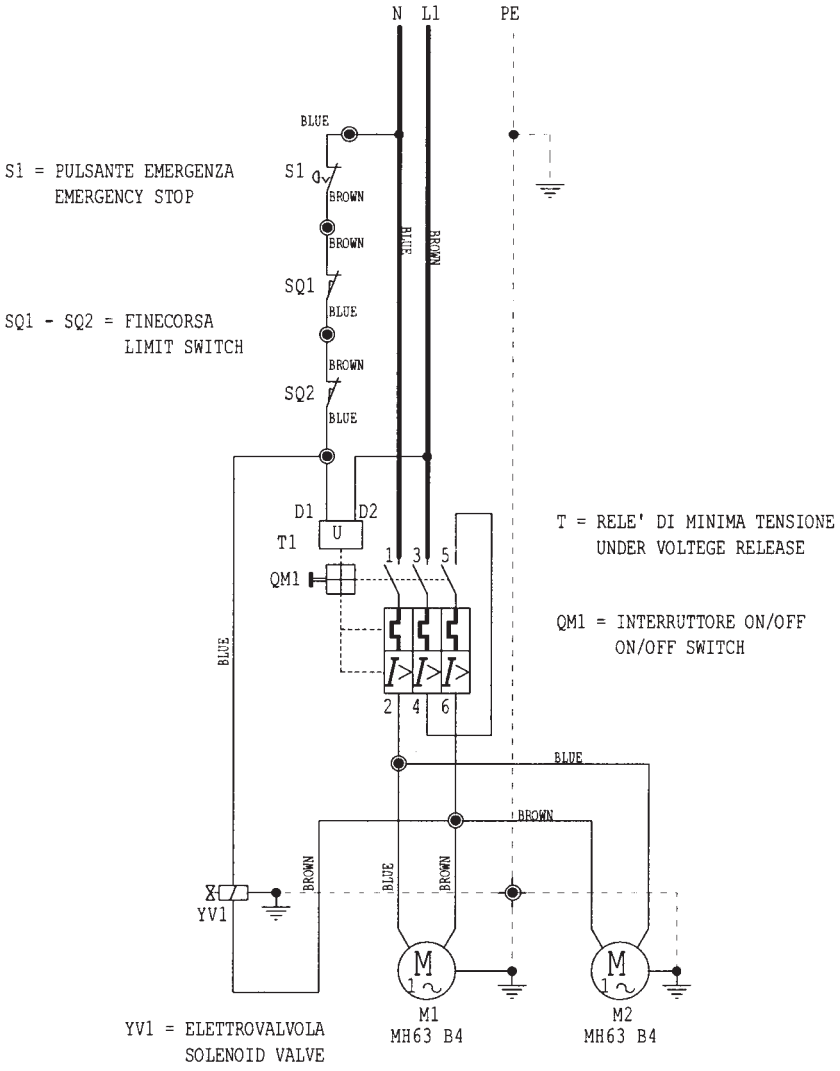
Le etichette applicate sulla macchina sono importanti per la sicurezza dell'operatore.
Nel caso di danneggiamento o di asportazione di qualsiasi etichetta, é responsabilità dell'utilizzatore sostituirla immediatamente.
Per ordinare le etichette di ricambio, si prega di fare riferimento ai numeri di codice riportati nella Figura 5709 del catalogo ricambi.

15.3 INDICAZIONI SULLE EMISSIONI DI RADIAZIONI, GAS, VAPORI, POLVERI

Nulla da segnalare

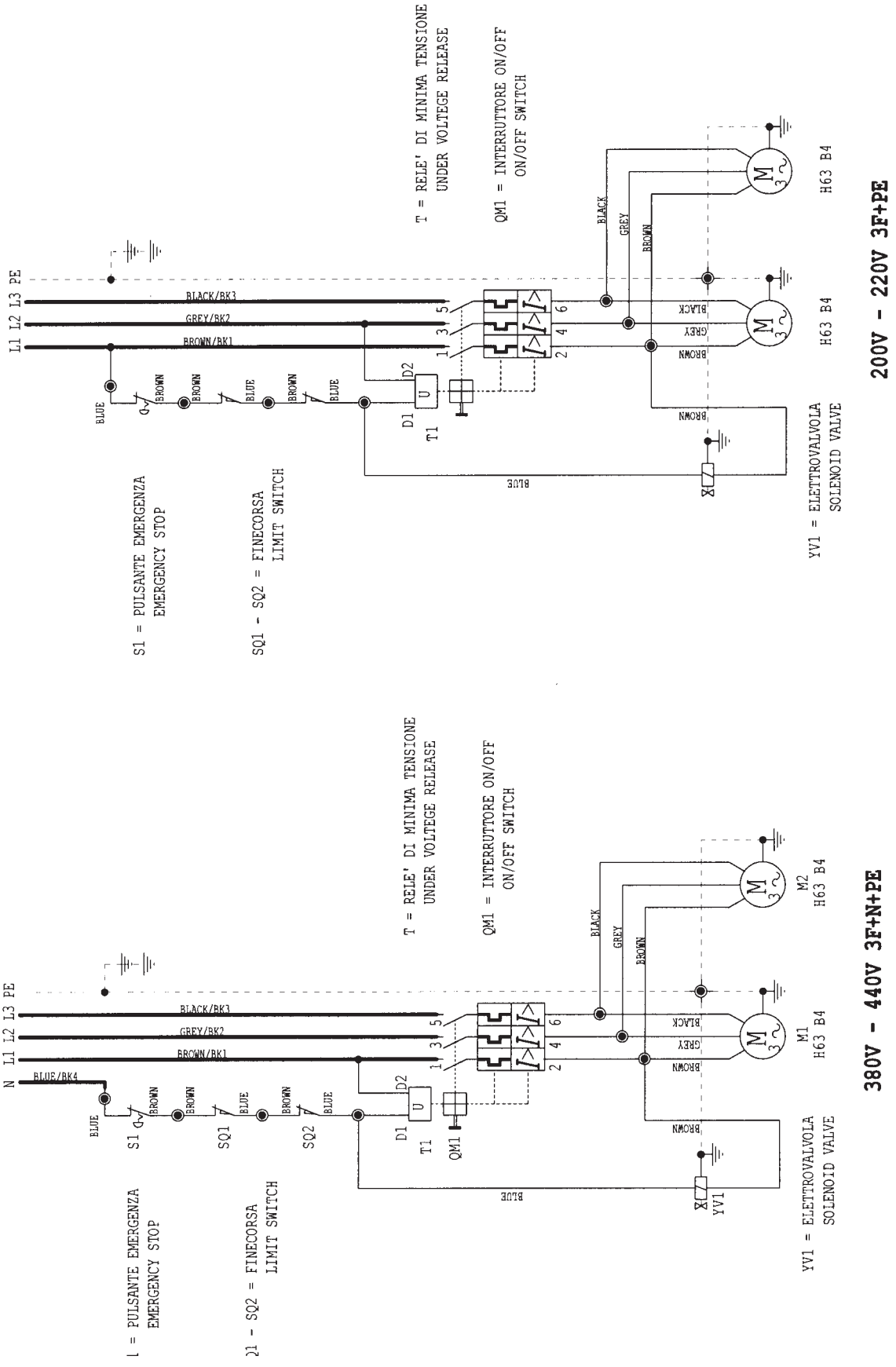
15.4 PROVE ELETTRICHE

Prove elettriche:
1 - Continuità del circuito di protezione
2 - Resistenza di isolamento
3 - Tensione di isolamento
In riferimento EN 60204-1, Par. 20.2, 20.3, 20.4



100V - 240V MF+PE

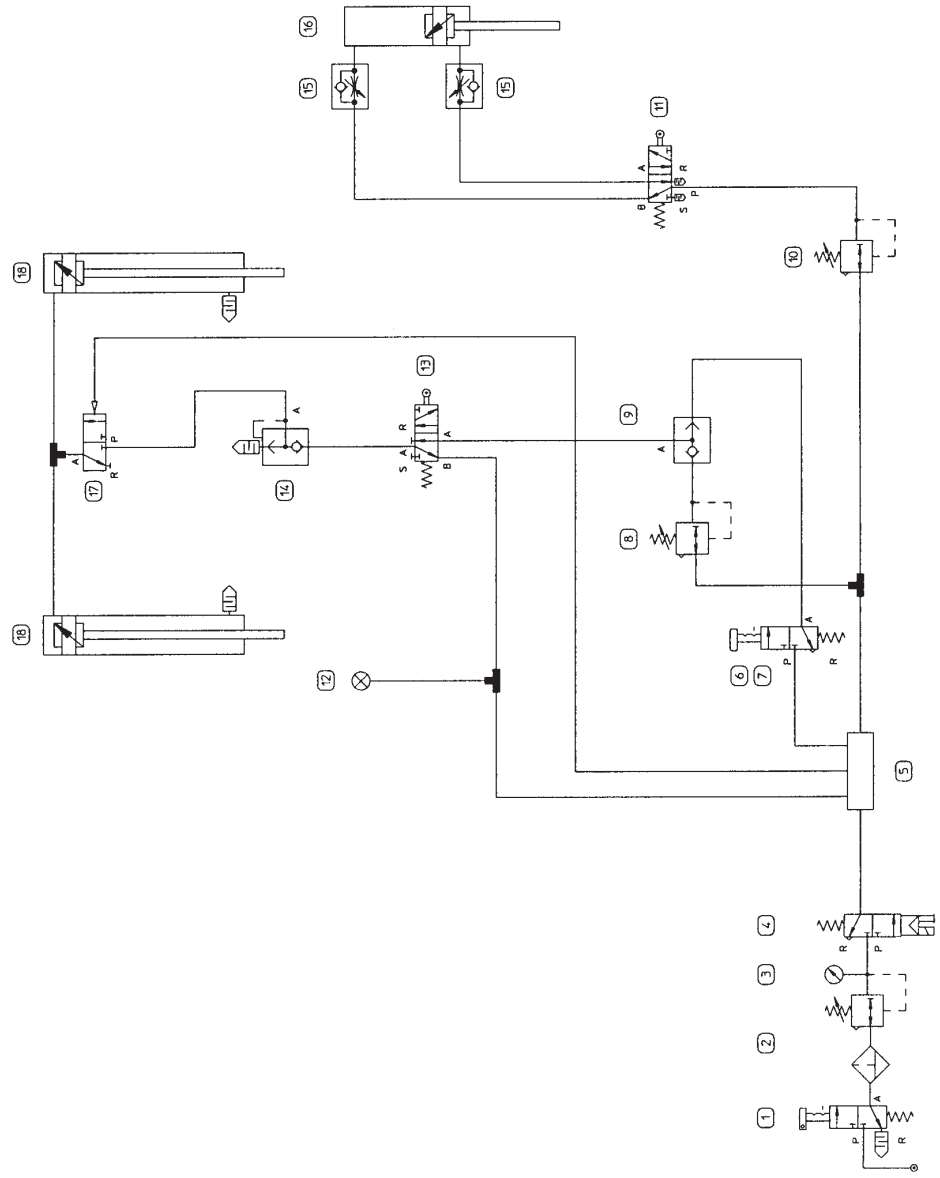
16- DISEGNI E SCHEMI



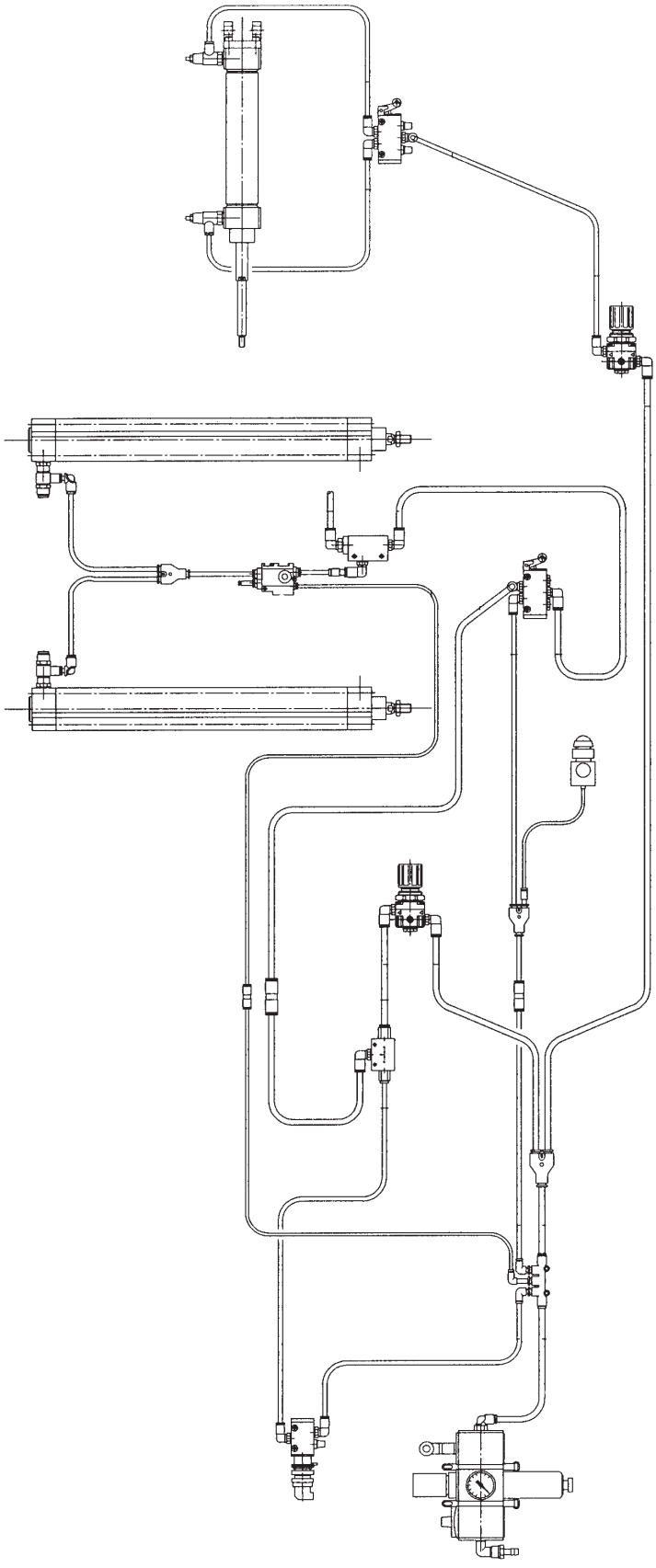
16- DISEGNI E SCHEMI

Legenda

18	2	SCB0000177	CILINDRO ALESAGGIO 40 CORSA 600
17	1	SCB0000195	VALVOLA 3/2
16	1	S3807867004	CILINDRO ALESAGGIO 40 CORSA 150
15	2	S3802977ZZZ	REGOLATORE DI FLUSSO
14	1	SCB0000190	VALVOLA DI SCARICO RAPIDO
13	1	SCB0000192	VALVOLA 5/2
12	1	S3801218ZZZ	INDICATORE OTTICO
11	1	SCB0000192	VALVOLA 5/2
10	1	SCB0000189	RIDUTTORE DI PRESSIONE
9	1	SCB0000191	VALVOLA SELETTRICE
8	1	SCB0000188	RIDUTTORE DI PRESSIONE
7	1	SCB0000193	VALVOLA 3/2
6	1	SCB0000194	AZIONATORE A LEVA
5	1	S3803160ZZZ	RACCORDO MULTI TE 8 - 6
4	1	SCB0000024	ELETTROVALVOLA
3	1	S3800670ZZZ	MANOMETRO 0-12 Atm
2	1	SCB0000023	FILTRO RIDUTTORE
1	1	SCB0000022	VALVOLA LUCCHETTABILE



16- DISEGNI E SCHEMI



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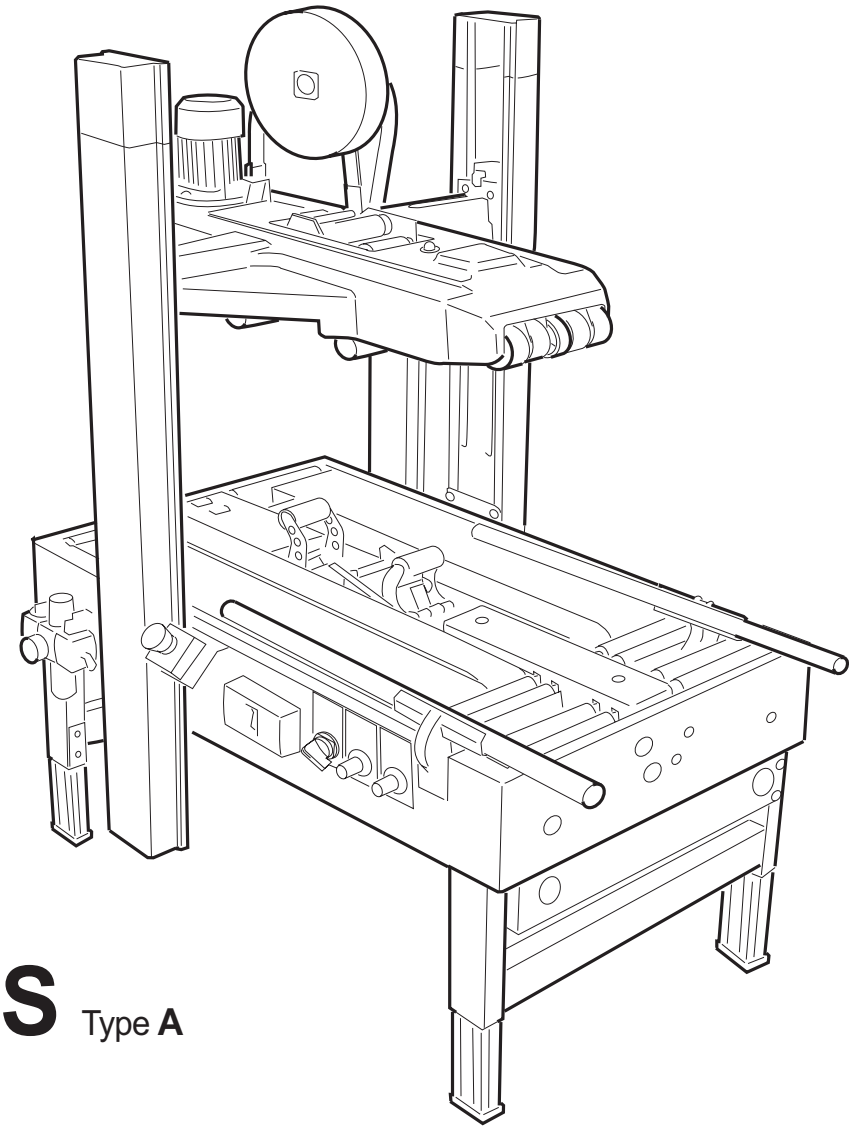

SR46-S Type **A**

NASTRATRICE AUTOMATICA
AUTOMATIC CASE SEALING MACHINE
MACHINE ENRUBANNEUSE AUTOMATIQUE
AUTOMATISCHE KARTONVERSCHLIESSMASCHINE
PRECINTADORA AUTOMATICA

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO
INSTRUCTIONS MANUAL AND SPARE PARTS LIST
MANUAL D'INSTRUCTIONS ET PIECES DETACHEES
BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE
MANUAL DE INSTRUCCIONES Y RECAMBIOS

CE

Publication code: SMB00049K

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Tel. 02-964951 - Telefax 02-9689727
http://www.siat.com - E-Mail: siat@siat.com

Instruction manual for the use, safety, maintenance and spare parts concerning the case sealing machine model SR46-S Type A.

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Edition January 2007

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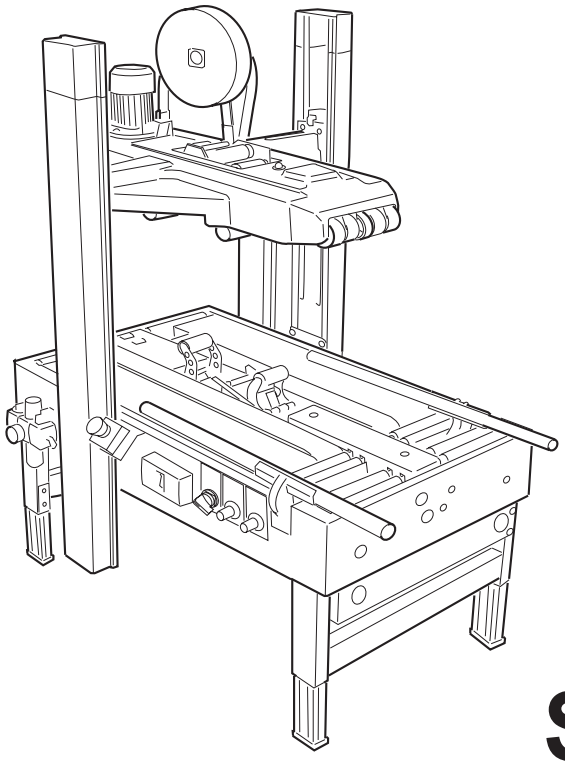
The manufacturer reserves the right to modify the product at any time without notice.

Publication n. SMB00049K
Release **I**



SR46-S Type **A**

AUTOMATIC ADJUSTMENT CASE SEALING MACHINE WITH TOP AND BOTTOM DRIVE BELTS

-Maximum box size **h**. 750 mm x **w.** 650 mm
-Adhesive tape 75 mm
-Belt speed 22 m per minute
-Production 650 boxes per hour (average)

	Section
Manufacturing specifications	1.1
Manual, how to use the	1.2
Serial Number	2.1
After-sale service	2.2
Warranty	2.3
Safety	**3**
Operators' skill levels	3.6
Technical specifications	4
Dimensions and weight	4.2.-4.6
Noise measurement	4.10
Transportation	5
Unpacking	6
Installation	7
Theory of operation	8
Controls	9
Safety devices	10
Set-up and adjustments	11
Tape replacement	11.1-11.2
Operation	12
Cleaning	12.5
Trouble shooting	12.8
Maintenance	13
Lubrication	13.5
Blade replacement	13.9
Belt replacement	13.10-13.11
Adjustment of belt tension	13.12
Log of maintenance work	13.13
Fire emergency	14.2
Enclosures	15
Electric Schematics	16
Pneumatic Schematic	16
Spare parts	last section

ABBREVIATIONS AND ACRONYMS

LIST OF ABBREVIATIONS, ACRONYMS AND UNUSUAL TERMS TO BE FOUND IN THIS MANUAL

Dwg.	=	drawing
Encl.	=	enclosure
Ex.	=	example
Fig.	=	figure showing spare parts
Max.	=	maximum
Min.	=	minimum
Mod.	=	machine model
N.	=	number
N/A	=	not applicable
OFF	=	machine stopped
ON	=	machine running
OPP	=	oriented polypropylene adhesive tape
Pict.	=	picture
PLC	=	Programmable Logic Control
PP	=	polypropylene
PTFE	=	Polytetrafluorethylene
PVC	=	Polyvinylchloride
Ref.	=	reference mark
SIAT SPA	=	Società Internazionale Applicazioni Tecniche (Società per Azioni)
Tav.	=	Illustration

w	=	width
h	=	height
l	=	length
ol	=	overall length
cbh	=	conveyor bed height

INTRODUCTION

1.1 MANUFACTURING SPECIFICATIONS

The automatic case sealing machine Mod. SR46-S has been designed and manufactured compling with the legal requirements in force at the date of its manufacture.

THE REFERENCE DOCUMENTS ARE:
Directive 98/37/CEE on the standardisation of member States legislation on machines.
Directive 89/336/EEC on the standardisation of member States legislation on electromagnetic compatibility.
Directive 73/23/EEC on the standardisation of member States legislation on electrical materials to be used within certain voltage limits.
UNI EN 292-1 Safety of machinery. Basic concepts general principles for design. Basic terminologym methodology.
UNI EN 292-2 Safety of machinery. Basic concepts general principles for design. Technical priciples and specifications
UNI EN 294 Safety of machinery. Safety distances to prevent danger zones being reached by the upper limbs.
UNI EN 349 Safety of machinery. Minimum gaps to avoid crushing of parts of the human body.
UNI EN 418 Safety of machinery. Emergency stop equipment, functional aspects. Principles for design.
UNI EN 457 Safety of machinery. Auditory danger signals. General requirements, design and testing.
UNI EN 954 Safety of machinery. Safety-related parts of control systems - General principles for design.
UNI EN 1050 Safety of machinery. Principles or risk assessment.
CEI EN 60204-1 Safety of machinery. Electrical equipment of machines. Part 1: General requirement.

1.2 HOW TO READ AND USE THE INSTRUCTION MANUAL

1.2.1 IMPORTANCE OF THE MANUAL

The manual is an important part of the machine; all information contained herein is intended to enable the equipment to be maintained in perfect condition and operated safely. Ensure that the manual is available to all operators of this equipment and is kept up to date with all subsequent amendments. Should the equipment be sold or disposed of, please ensure that the manual is passed on. Electrical and pneumatic diagrams are included in the manual. Equipment using PLC controls and/or electronic components will include relevant schematics or programmes in the enclosure, and in addition the relevant documentation will be delivered separately.

1.2.2 MANUAL MAINTENANCE

Keep the manual in a clean and dry place near the machine. Do not remove, tear or rewrite parts of the manual for any reason.
Use the manual without damaging it.
In case the manual has been lost or damaged, ask your after sale service for a new copy, quoting the code number of the document.

1.2.3 CONSULTING THE MANUAL

The manual is composed of:
- pages which identify the document and the machine;
- index of the subjects:
- instructions and notes on the machine: sections **2÷14**
- enclosures, drawings and diagrams:
  sections **15÷16**
- spare parts: last section.

All pages and diagrams are numbered. The spare parts lists are identified by the figure identification number.
All the notes on safety measures or possible dangers are identified by the symbol:

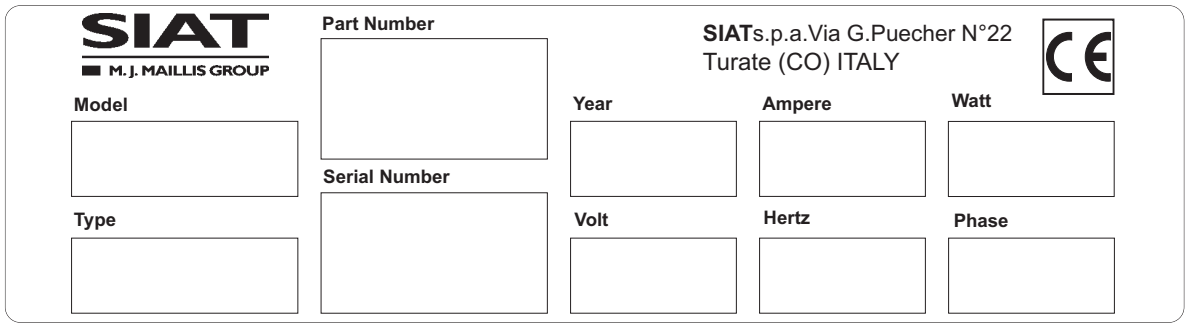
All the important warning notes related to the operation of the machine are identified by the symbol:
The parts typed in **bold** refer to technical data or technical notes on a specific subject.

1.2.4 HOW TO UPDATE THE MANUAL IN CASE OF MODIFICATIONS TO THE MACHINE

Modifications to the machine are subject to manufacturer's internal procedures.
The user receives a complete and up-to-date copy of the manual together with the machine.
Afterwards the user may receive pages or parts of the manual which contain amendments or improvements made after its first publication.
The user must use them update this manual.

2-GENERAL INFORMATION

2.1 SERIAL NUMBER OF THE MACHINE AND NAME OF THE MANUFACTURER



2.2 FOR AFTER-SALE SERVICE AND SPARE PARTS PLEASE APPLY TO:

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22078 TURATE (CO) - ITALY

Tel. 02-964951
Fax. 02-9682239
E-mail siat@siat.com

AGENT/DISTRIBUTOR OR LOCAL
AFTER SALE SERVICE:

2.3 WARRANTY

Within the limits of what is set forth below, Seller agrees to repair or replace without cost to Buyer any defective goods when such defect occurs within a period of six (6) months from the date in which Seller's goods have been put into use, but in no event beyond eight (8) months from the date of shipment.

Expressly excluded from this warranty are those parts subject to normal wear and tear (by way of illustration, but not limitation, such parts as belts, rubber rollers, gaskets, brushes, etc.) and electrical parts.

Buyer must immediately notify Seller of any defect, specifying the serial number of the machine.

Buyer shall send to Seller the defective item for repair or replacement. Seller will perform the repairs or provide a replacement within a reasonable period of time.

Upon effecting such repair or replacement, Seller shall have fulfilled its warranty obligations. In the event the repairs or replacement must be effected at the place where the machine is installed, all expenses for labor, travel and lodging of Seller's personnel shall be sustained by the Buyer. Buyer will be invoiced in conformity with Seller's standard charges for the services rendered.

Seller is not responsible for defects resulting from:

- Improper use of the machine
- Lack of proper maintenance
- Tampering with the machine or repairs effected by the Buyer.

Seller will not be liable for any injury to persons or things or for the failure of production. With respect to the materials not manufactured by Seller, such as motors and electrical equipment, Seller will grant to Buyer the same warranty Seller receives from its supplier of such materials. Seller does not warrant the compliance of its machines with the laws of non-EEC countries in which the machines may be installed, nor does it warrant compliance with laws or standards relating to the prevention of accidents or pollution.

Adaptation of Seller's machines to the aforesaid laws or standards shall be the responsibility of Buyer who assumes all liability therefore.

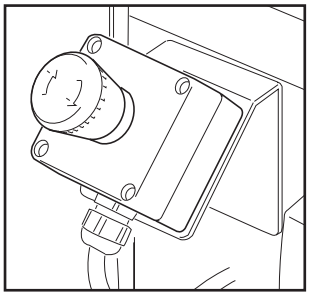
Buyer shall indemnify and hold Seller harmless against any claim by third parties resulting from failure to comply with the aforesaid laws and standards.

3-SAFETY

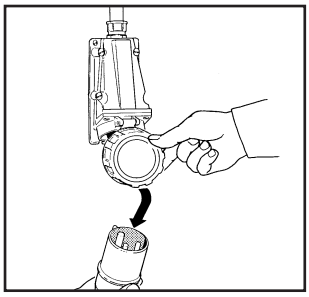
3.1 GENERAL SAFETY INFORMATION

Read all the instructions carefully before starting the work with the machine; please pay particular attention to sections marked by the symbol

The machine is provided with a LOCKABLE EMERGENCY STOP BUTTON placed on the operator side of the machine; when this button is pressed, it stops the machine at any point in the working cycle without cutting the pneumatic circuit.



Disconnect the machine from the mains before any maintenance operation.



Keep this manual in a handy place near the machine: its information will help you to maintain the machine in good and safe working condition.

3.2 DEFINITION OF THE OPERATORS' QUALIFICATIONS

- Machine operator
- Maintenance technician
- Electrician
- Manufacturer’s technician

Only persons who have the skills described in the following page should be allowed to work on the machine. It is the responsibility of the user to appoint the operators having the appropriate skill level and the appropriate training for each category of job.

SKILL 1

MACHINE OPERATOR
This operator is trained to use the machine with the machine controls, to feed cases into the machine, make adjustments for different case sizes, to change the tape and to start, stop and restart production.
N.B.: the factory manager must ensure that the operator has been properly trained on all the machine functions before starting work.

SKILL 2

MECHANICAL MAINTENANCE TECHNICIAN
This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to work with the safety protection disconnected, to check and adjust mechanical parts, to carry out maintenance operations and repair the machine.
He is not allowed to work on live electrical components.

SKILL 2a

ELECTRICAL MAINTENANCE TECHNICIAN
This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to work with the safety protection disconnected, to make adjustments, to carry out maintenance operations and repair the electrical components of the machine.
He is allowed to work on live electrical panels, connector blocks, control equipment etc.

SKILL 3

SPECIALIST FROM THE MANUFACTURER
Skilled operator sent by the manufacturer or its agent to perform complex repairs or modifications, when agreed with the customer.

3.3 INSTRUCTIONS FOR A SAFE USE OF THE MACHINE

Only persons who have the skills described on the following paragraph **3.6** are allowed to work on the machine.
It is responsibility of the user to appoint the operators having the appropriate skill level and the appropriate training for each category of job.

3.4 STATE OF THE MACHINE

List of the modes which are possible with this machine:
- automatic running;
- running with safety protections removed or disabled;
- stopped by using the main switch;
- stopped by using the lockable emergency stop button;
- electric power disconnected;
- compressed air disconnected.

3.5 NUMBER OF THE OPERATORS

The operations described hereinafter have been analized by the manufacturer; the number of operators shown for each operation is suitable to perform it in the best way.
A smaller or larger number of operators could be unsafe.

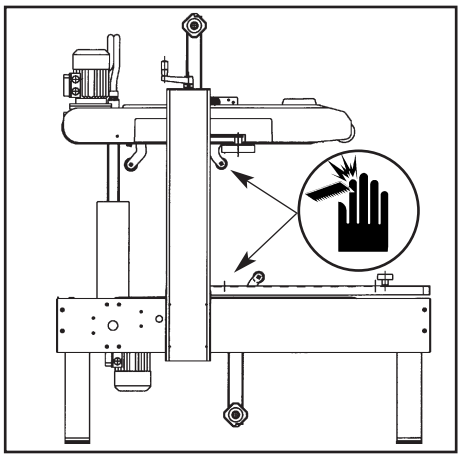
3.6 OPERATORS' SKILL LEVELS

The table below shows the minimum operator's skill for each operation with the machine.

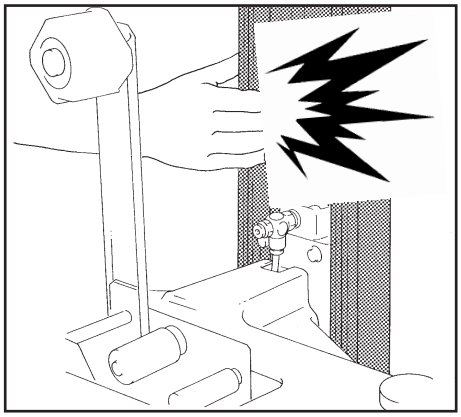
OPERATION	STATE OF THE MACHINE	OPERATOR'S SKILL	NUMBER OF OPERATORS
Installation and set up of the machine.	Running with safety protections disabled.	**2 and 2a**	2
Adjustment of the box size.	Stopped by pressing the EMERGENCY STOP button.	**1**	1
Tape replacement.	Stopped by pressing the EMERGENCY STOP button.	**1**	1
Replacement of blades.	Electric power disconnected.	**2**	1
Replacement of drive belts.	Electric and pneumatic power disconnected.	**2**	1
Ordinary maintenance (mechanical).	Electric and pneumatic power disconnected.	**2**	1
Ordinary maintenance (electrical).	Electric and pneumatic power disconnected.	**2a**	1
Extraordinary maintenance (mechanical).	Running with safety protections disabled.	**3**	1
Extraordinary maintenance (electrical).	Running with safety protections disabled.	**3**	1

3.7 RESIDUAL HAZARDS

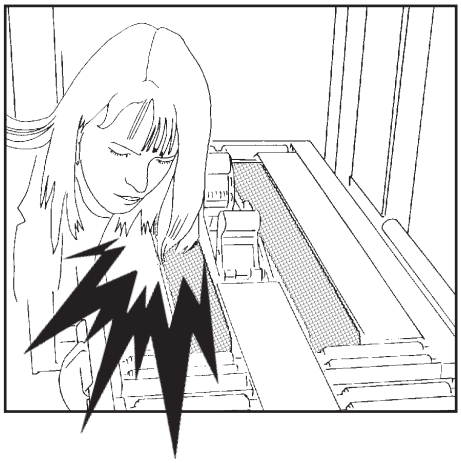
The case sealer SR46-S has been designed following the CE 392 directives, and incorporates various safety protections which should never be removed or disabled.
Notwithstanding the safety precautions conceived by the designers of the machine, it is essential that the operator and service personnel be warned that the following uneliminable residual hazards exis



WARNING! Tape cutting blades.
Never remove the safety device which covers the blade on the top and bottom taping units.
Blades are extremely sharp. Any error may cause serious injuries.

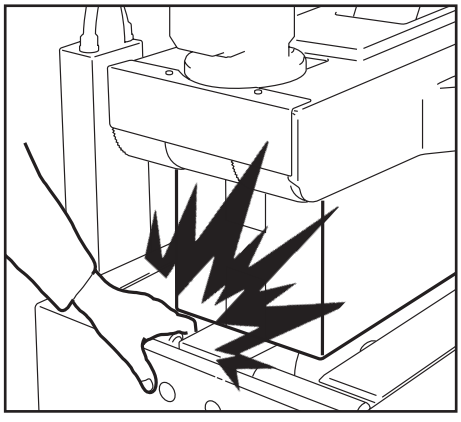


WARNING! Pneumatic drives of the upper head housed inside the columns.
Keep hands away.



WARNING! Upper and lower drive belts.

Never work on the machine with loose hair or loose garments such as scarfs, ties or sleeves.
Although protected, the drive belts may be dangerous.



WARNING! Cavity in the conveyor bed.

Never put your hands inside any part of the machine while it is working.
Serious injury may occur.

WARNING! Top driving belts.

Never touch the running belt with your hands.
Serious injury may occur.

3.8 RECOMMENDATIONS AND MEASURES TO PREVENT OTHER HAZARDS WHICH CANNOT BE ELIMINATED

The operator must stay on the working position shown on paragraph 12.1. He must never touch the running driving belts or put his hands inside any cavity.
The box must be fed by keeping the hands in the right position. (see paragraph 4.9)
The operator must pay attention to the blades during the tape replacement.

3.9 PERSONAL SAFETY MEASURES

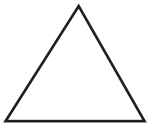
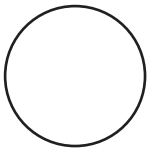
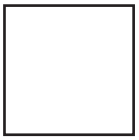
(Safety glasses, safety gloves, safety helmet, safety shoes, air filters, ear muffs).
None is required, except when recommended by the user.

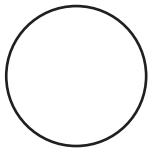
3.10 PREDICTABLE ACTIONS WHICH ARE INCORRECT AND NOT ALLOWED

- Never try to stop or hold the box while it is being driven by the belts.
  Use only the EMERGENCY STOP BUTTON.
- Never work without the safety protections.
- Never remove or disable the safety devices.
- Only authorised personnel should be allowed to carry out the adjustments, repairs or maintenance which re quire operation with reduced safety protections. During such operations, access to the machine must be re stricted. When the work is finished, the safety protections must immediately be reactivated.

- The cleaning and maintenance operations must be performed after disconnecting the electric power.
- Clean the machine using only dry clothes or light detergents. Do not use solvents, petrols etc.
- Do not modify the machine or any part of it. The manufacturer will not be responsible for any modifications.
- We advise to apply directly to Siat for modifications.
- Follow carefully the installation instructions of this manual. The manufacturer will notbe responsible for dama ges caused by improper installation.

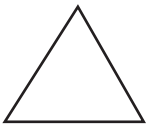
3.11 TABLE OF WARNINGS, LABELS, PLATES AND DRAWINGS TO BE FOUND ON THE MACHINE

	SYMBOLS	COLOURS
	DANGER AND PARTS IN MOVEMENT	YELLOW COLOUR
	COMPULSORY ACTIONS/PROHIBITION	RED COLOUR
	CONTROLS AND INFORMATION	LIGHT BLUE COLOUR

a 

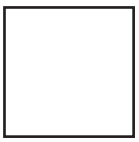
Warns the operator that the adjustable upper head cylinder stop must not be released if compressed air is OFF.

Label code: 3.0.010604.96/A

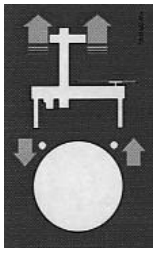
b 

Warns the operator not to touch the lever that actuates the valve for the upper head ascent.

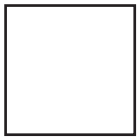
Label code: 3.0.01029.96A

c 

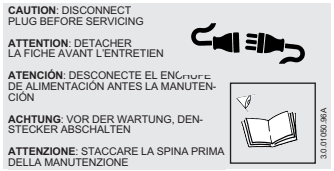
Show the selector to raise/lower the upper head assembly to make easily accessible the bottom taping unit for tape replacement.



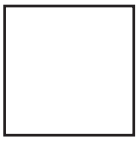
Label code: 3.0.01047.96A

d 

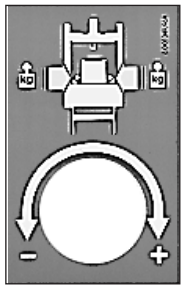
Before starting any maintenance operations the electrical power must be disconnected.



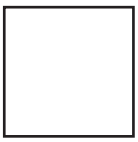
Label code: 3.0.01050.96A

e 

Show the knob to adjust the pressure of the side guides againts the box.

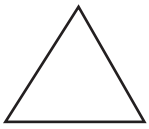


Label code: 3.0.01049.96A

f 

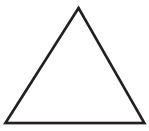
Show the knob to adjust the weight of the upper head assembly on the box.

Label code: 3.0.01048.96A

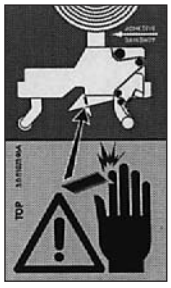
g 

Show the sharp knife on the taping head.

Label code: 3.0.01028.96A

h 

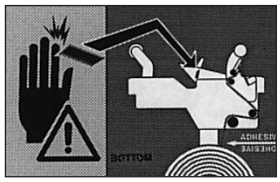
Tape threading path for top taping unit, and position of the sharp knife.



Label code: 3.0.01023.96A

i

Tape threading path for bottom taping unit and position of the sharp knife.



LAbel code: 3.0.01024.96A

l

Show the running direction of the belts.

Label code: 3.0.01040.96A

m

Show that airs is in the circuit (red indicator is up).

Label code: 3.0.01035.96A

n

Warns the operator not to touch the lever that actuates the closing/opening of the box side guides.

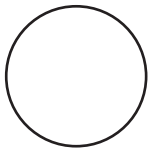
Label code: 3.0.01027.96A

o

Warns the operator not to introduce the hands into the ca vities of the box side guides.

Label code: 3.0.01036.96A

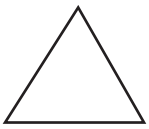
p



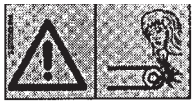
Warns the operator to keep hands away from the pneumatic cylinder housed inside the columns.

LAbel code: 3.0.01041.96A

q

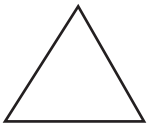


Shows the danger of the upper drive belts when run ning.



Label code: 3.0.01030.96A

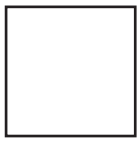
r



Show the danger of the bottom drive belts when running.

Label code: 3.0.01031.96A

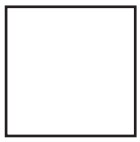
s



Show the start/stop control and that inside thwe circuit brea ker box there is electric currenty.

Label code: 3.0.01090.96A

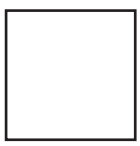
t



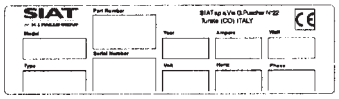
Show the point for eartjh wire connection on the machine frame.

Label code: 3.0.01039.96A

u



Identification data for the machine model, serial number and manufacturer.



Label code: SBC0000629

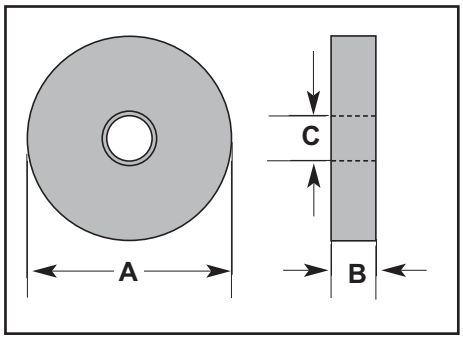
4-PRELIMINARY INFORMATION ON THE MACHINE

4.1 GENERAL DESCRIPTION OF THE MACHINE

Automatic case sealer with top and bottom drive belts and automatic adjustment to the box size to be sealed.

4.2 TECHNICAL SPECIFICATIONS

- Production = 650 boxes/hour (average)
- Standard power supply = 230/400 V 50Hz 3Ph
- N.2 motors (HP 0,18) KW 0,12
- Taping units K12, tape width 75 mm.
- Weight = 165 kg.
- Belts speed = 22 m per minute
- Compressed air = 6 Bar max.



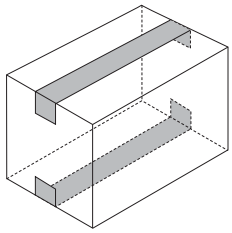
A = 410 mm max
B = 75 mm
C = 76 mm

4.3 TAPE DIMENSIONS

Suitable adhesive tapes:
PVC
OPP
ADHESIVE PAPER

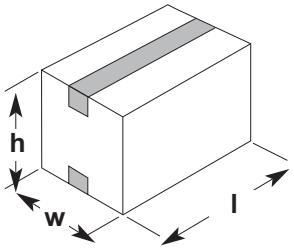
4.4 PURPOSE OF THE MACHINE

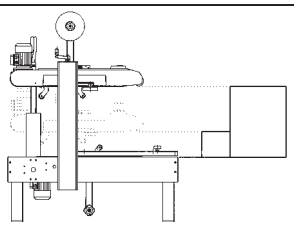
The machine is designed to seal with adhesive tape cases having the dimensions (in millimeters) shown in section **4.5**, by applying two tape stripes on their top and bottom flaps simultaneously.



4.5 BOX-SIZE RANGE

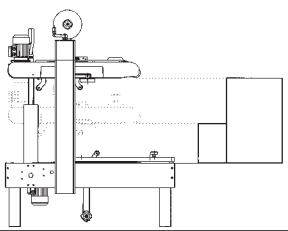
The case sealer SR46-S is automatically adjustable to any box sizes included in the range shown below (part **1**).
To seal boxes higher than 750 mm, it is possible to modify the position of the outer columns as shown in the drawing below (part **2**).





1 OUTER COLUMNS IN LOW POSITION

BOX SIZE		MIN	MAX
	L	**150**	
	W	**170**	**650**
	H	**130**	**750**



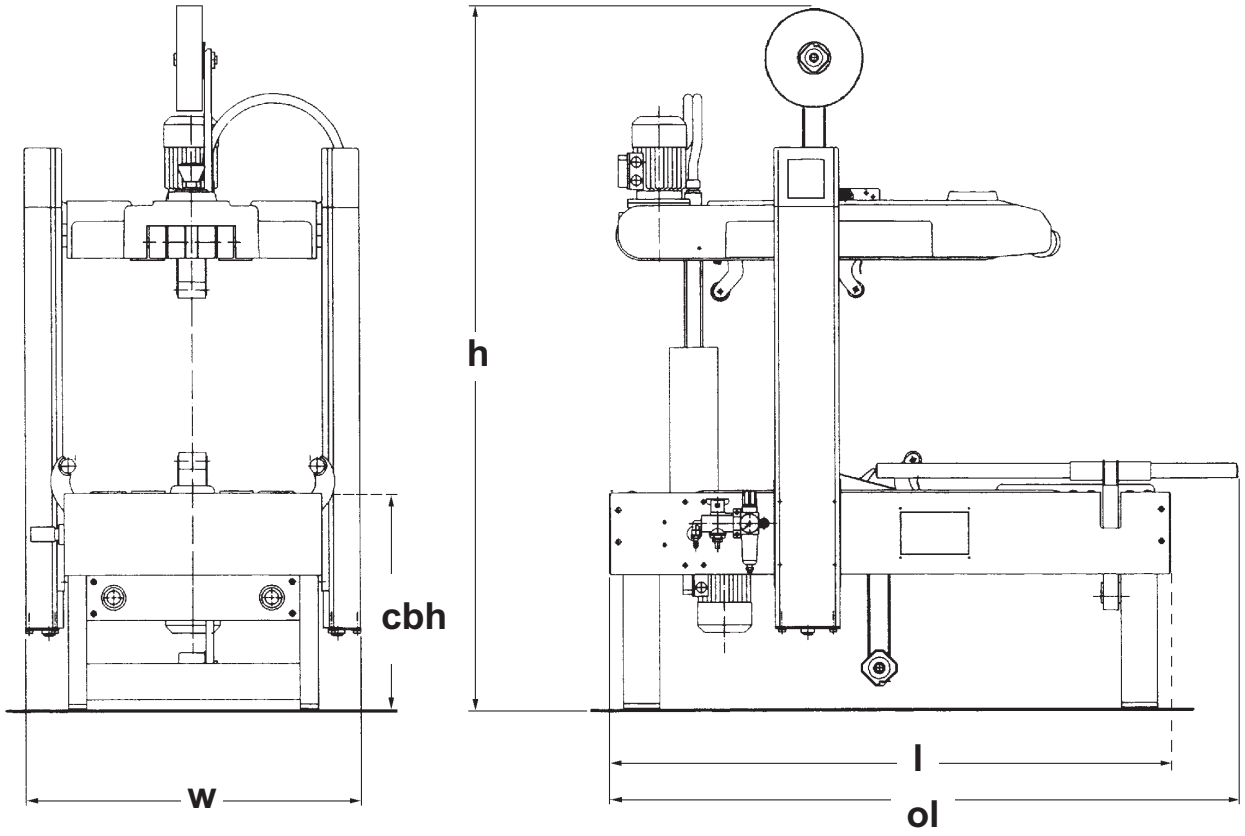
2 OUTER COLUMN IN HIGH POSITION

BOZ SIZE		MIN	MAX
	L	**150**	
	W	**170**	**650**
	H	**340**	**930**

NOTES

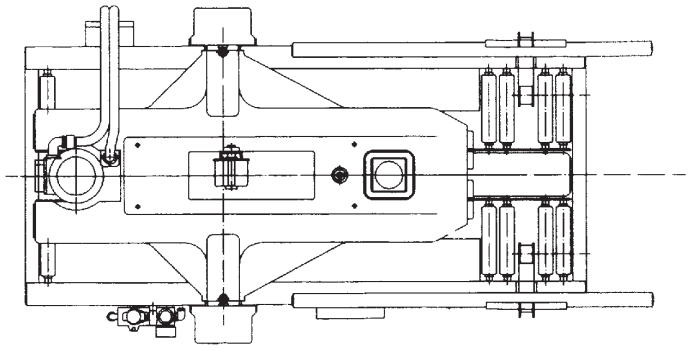
1 The box length (L) refers to the size in the seal direction.
1 The boxes should have a H/L ratio (HEIGHT/LENGTH) of 0,5 or higher.
Boxes with a lower ratio should be test run to ensure perfect performance, which depends upon various factors such as box weight and rigidity.
1 Some special modifications are available from the manufacturer in order to seal box formats smaller or larger than the standard sizes described herein. If interested, please contact your Siat Service Dealer

4.6 DIMENSIONS



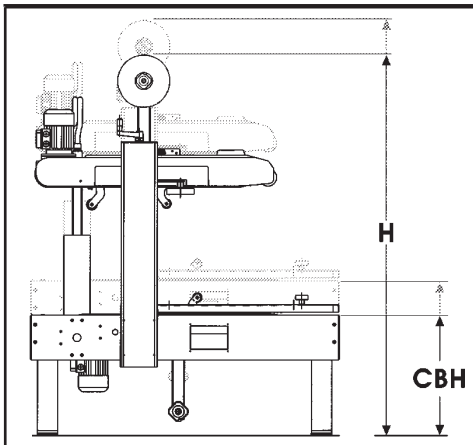
MACHINE OVERALL DIMENSIONS

l = length 1240 mm
w = width 940 mm
h = height 1275÷2025 mm
ol = overall length including centering bars: 1390 mm
cbh= conveyor bed height: section 4.7



4.7 CONVEYOR BED HEIGHT

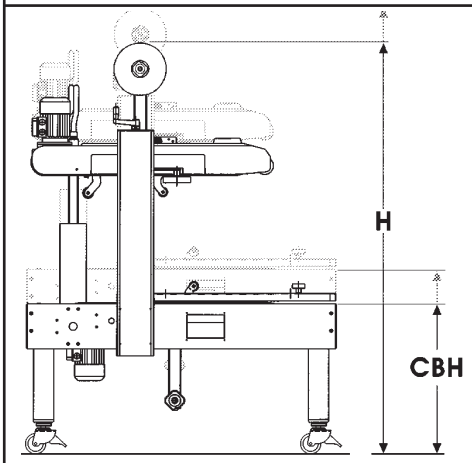
The case sealer SR46-S allows for a wide range of conveyor bed height. Various combinations are possible with the use of the optional accessories AS77 (casters) and AS80 (legs), as shown in the following page.



A WITH STANDARD LEGS

CONVEYOR BED HEIGHT	MIN	MAX
CBH	**485**	**825**

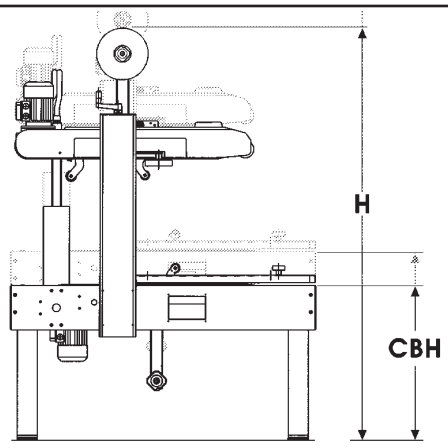
OVERALL DIMENSIONS	MIN	MAX
H	**1275**	**2025**
L	**1240**	**1240**
W	**940**	**940**



B WITH AS77 CASTERS (OPTIONAL)

CONVEYOR BED HEIGHT	MIN	MAX
CBH	**585**	**925**

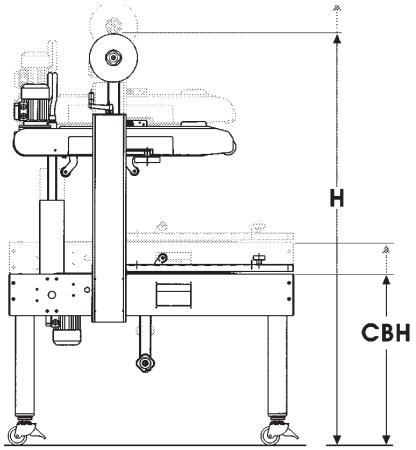
OVERALL DIMENSIONS	MIN	MAX
H	**1375**	**2125**
L	**1240**	**1240**
W	**940**	**940**



C WITH AS80 LEGS (OPTIONAL)

CONVEYOR BED HEIGHT	MIN	MAX
CBH	**645**	**1135**

OVERALL DIMENSIONS	MIN	MAX
H	**1435**	**2335**
L	**1240**	**1240**
W	**940**	**940**



D WITH AS80 LEGS AND AS77 CASTERS (OPTIONAL)

CONVEYOR BED HEIGHT	MIN	MAX
CBH	**745**	**1235**

OVERAL DIMENSIONS	MIN	MAX
H	**1535**	**2435**
L	**1240**	**1240**
W	**940**	**940**

4.8 MAIN COMPONENTS

The machine is composed of:

N. 1 frame
N. 4 adjustable legs
N. 2 columns
N. 2 taping units
N. 1 top head support
N. 1 top drive belts assembly
N. 1 bottom drive belts assembly
N. 2 electric motors
N. 1 emergency stop button
N. 1 main switch ON/OFF

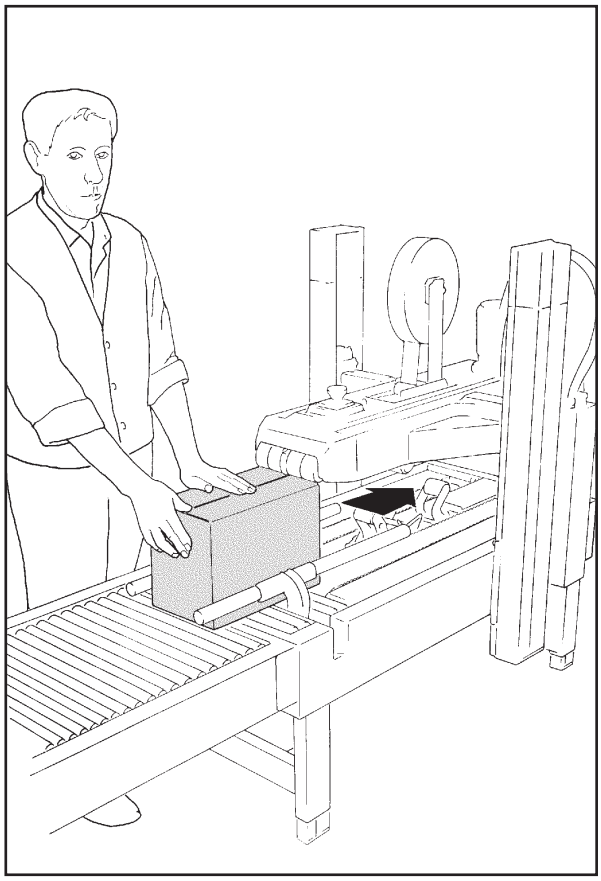
For the technical features of the electric parts refer to section **15-ENCLOSURES**

4.9 OPERATIVE FLOW

Once the box has been filled, close its top flaps and push it against the lever that controls the ascent of the upper head. Insert the box into the machine until it overhangs the drive belts that will drag it through the taping heads.

Keep hands always as shown on Picture.

The box will be automatically sealed with adhesive tape on the top and bottom box seams. Then it will be expelled on the exit conveyor.



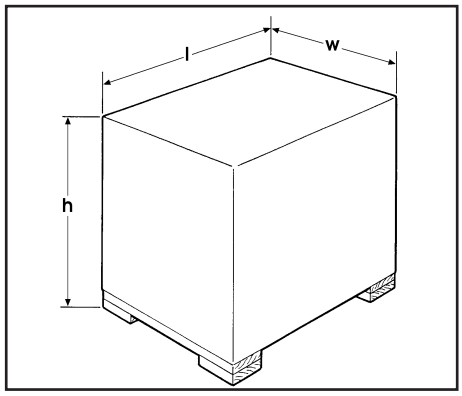
4.10 MACHINE NOISE MEASUREMENT

Acoustic pressure at 1 meter distance from the machine with the tape roll inserted: 73 dB. Acoustic pressure at a height of 1,6 meter above the machine with the tape roll inserted: 73 dB.
The measurement has been performed by a SPYRI-MICROPHON phonometer.

5-SHIPPING-HANDLING-PACKAGE

5.1 SHIPMENT AND HANDLING OF THE PACKED MACHINE

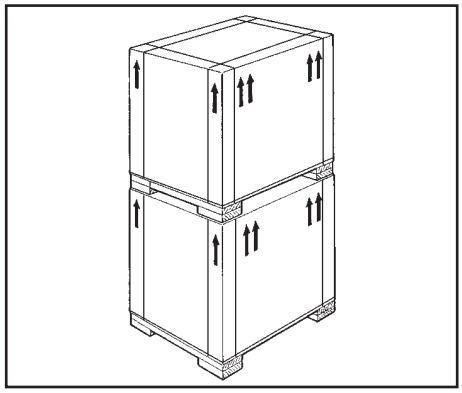
The machine is fixed on the pallet with four bolts and can be uplifted by using a forktruck.
The packaging is suitable to travel by land and by air. Optional sea-freight packaging available.



PACKAGING OVERALL DIMENSIONS

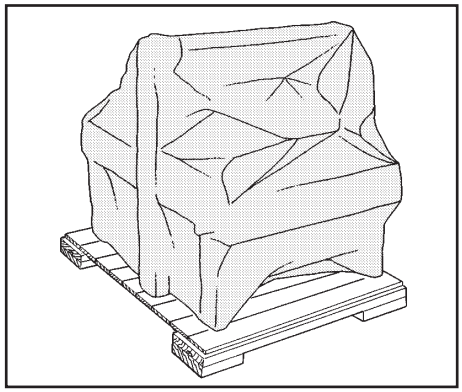
l = length 1400 mm
w = width 1000 mm
h = height 1300 mm
Weight kg. 210

During the shipment it is possible to stack a maximum of 2 machines.



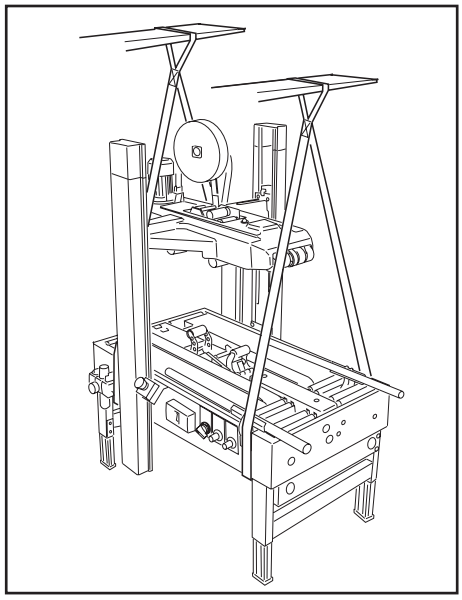
5.2 PACKAGING FOR OVERSEAS SHIPMENT

(OPTIONAL)
The machines shipped by sea freight are covered by an aluminum/polyester/ polythene bag which contains dehydrating salts.



5.3 SHIPMENT AND HANDLING OF THE UNPACKED MACHINE

The unpacked machine can only be moved short distances and indoors only.
The transportation of the machine without packaging may cause damage and accidents. In case it is necessary to relocate the machine, lift it with belts as shown in Picture.



MACHINE OVERALL DIMENSIONS

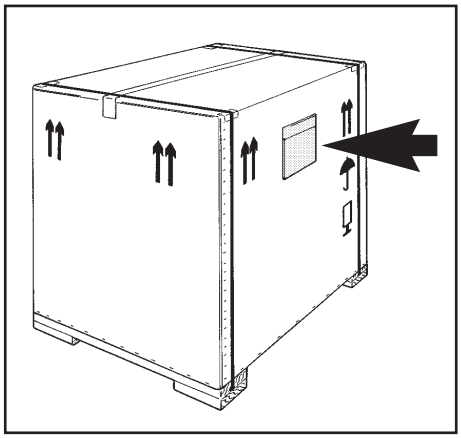
length 1240 mm.
width 940 mm.
height min.1275; max. 2025 mm.
Weight kg 165

5.4 STORAGE OF THE PACKED OR UNPACKED MACHINE

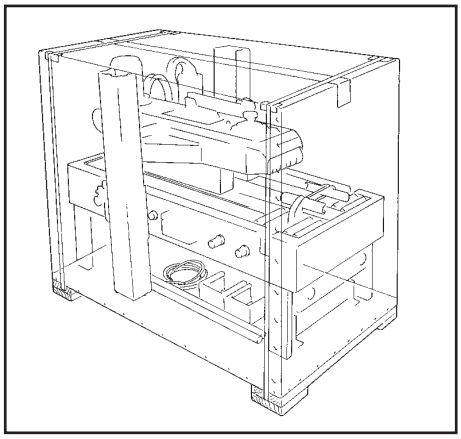
If the machine is left inactive for a long period, please take the following precautions:
-store the machine in a dry and clean place;
-if the machine is unpacked it is necessary to protect it from the dust and do not stack anything over the machine;
-it is possible to stack a maximum of 2 machines, if they are in their original packing.

6-UNPACKING

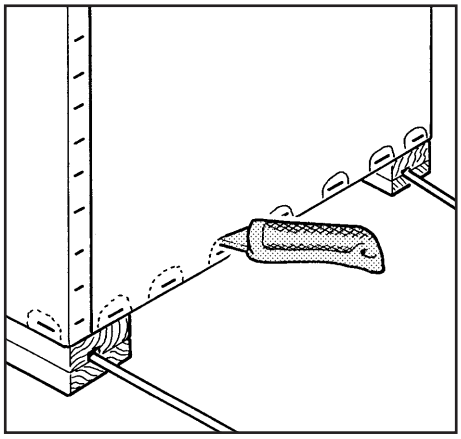
6.1 The envelope attached to the external side of the packing case contains the instructions concerning the unpacking of the machine.



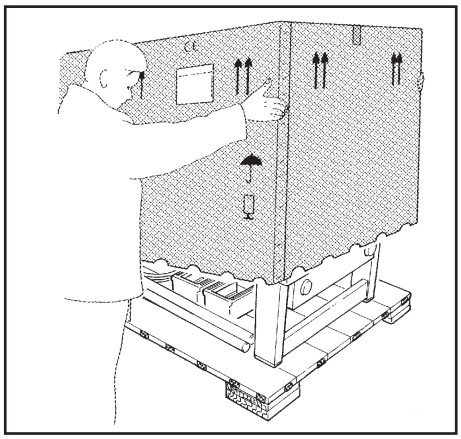
Machine layout inside the packing.



Cut the polypropylene straps. Use a cutter to remove the part of the case stapled to the pallet around the entire perimeter of the case. (Or remove the staples by using a suitable tool).

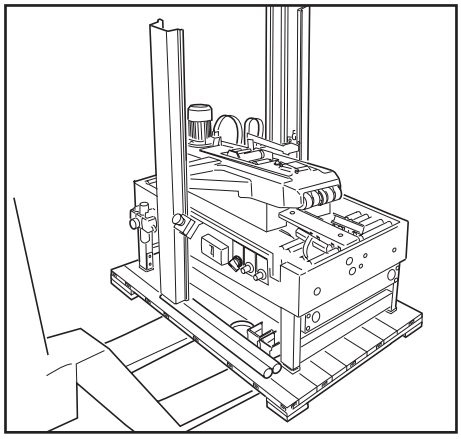


After having cut the carton or removed the staples, lift the case to free the machine. (2 persons).

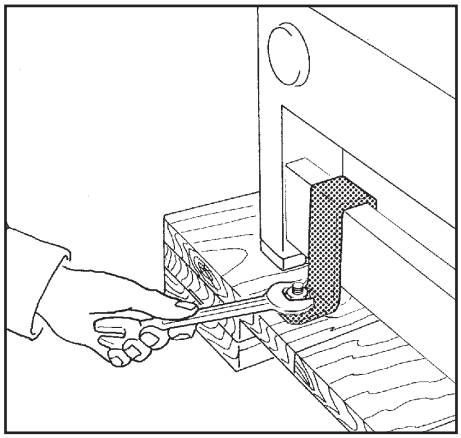


6-UNPACKING

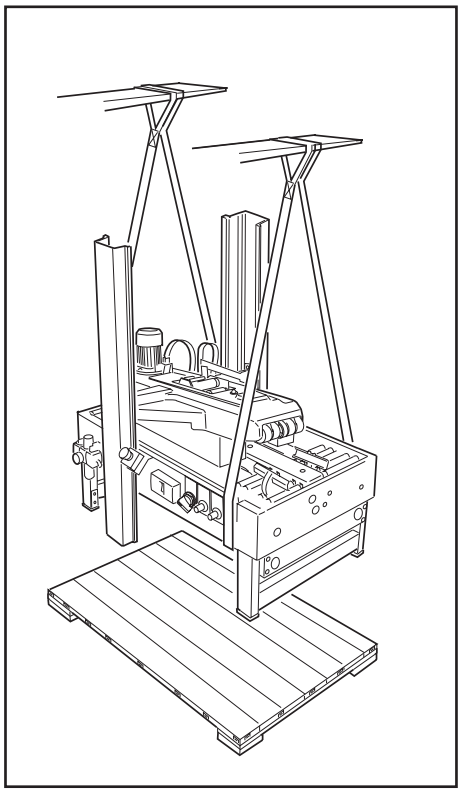
Use a forktruck to carry the machine to its working location.
(Weight of machine + pallet = Kg. 185)



Unscrew the nuts and remove the brackets which fix the machine to the pallet.



Uplift the machine by using belts or ropes. Pay attention to place the belts in the points shown in Picture and remove the wooden pallet (Machine weight 165 kg).



6.2 PACKAGING DISPOSAL

The packaging of the machine Mod. SR46-S is composed of:

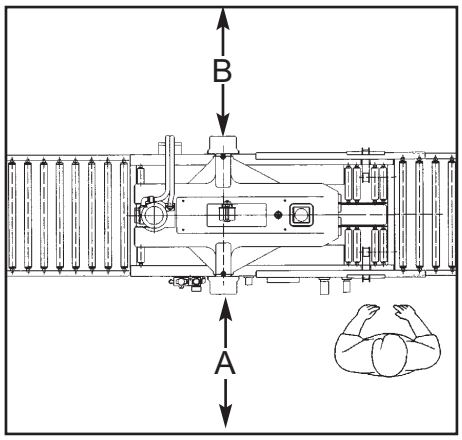
- wooden pallet
- cardboard box
- steel fixing brackets
- polythene foam protection
- plastic straps (PP)
- clay dehydrating pouches (only for seafreight shipments)
- aluminum/polyester/polythene bag (only for seafreight shipments)

For the disposal of these materials please follow the provisions of the law in your country.

7-INSTALLATION

7.0 SAFETY MEASURES

(Read section **3** carefully).



7.1 ENVIRONMENTAL CONDITIONS REQUIRED

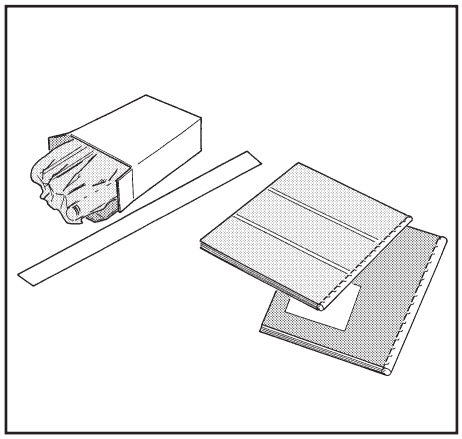
-Min. temperature = 5 °C; Max. temperature = 40 °C
-Min. humidity 30%; Max. humidity 80%
-Dust-free environment

7.2 SPACE REQUIRED FOR OPERATION AND MAINTENANCE

Min. distance from the wall:
A = **1000** mm.
B = **700** mm.
Min. height = **2500** mm.

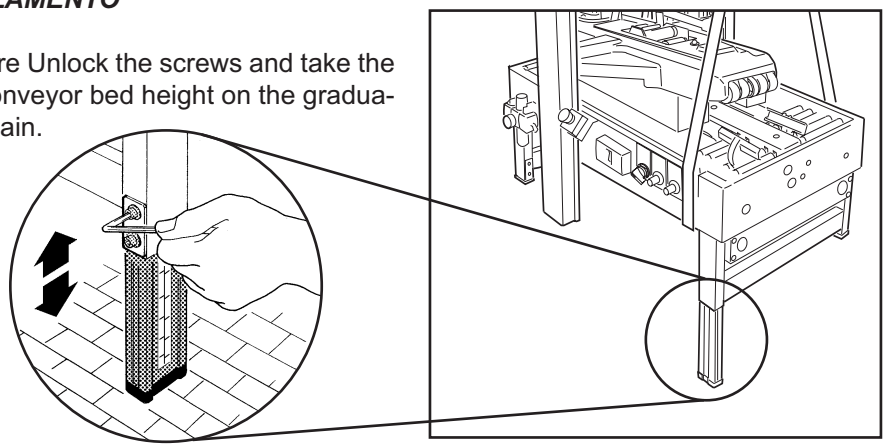
7.3 SPARE PARTS AND THREADING TOOL FOR TAPING HEADS SUPPLIED WITH THE MACHINE

For a detailed description see section **13.1.**



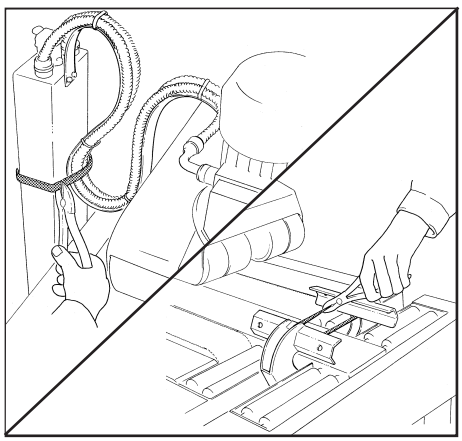
7.4 MACHINE POSITIONING - *PIAZZAMENTO*

Lift the machine as shown in Picture Unlock the screws and take the legs out looking for the desired conveyor bed height on the graduated label. Then lock the screws again.



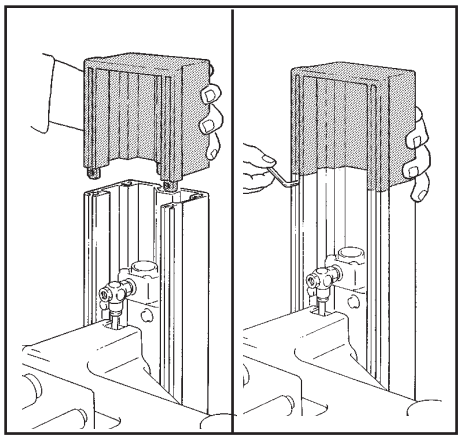
7.5 LOCKS REMOVAL

Cut the strap that keeps the centering levers as well as the strap that keeps the wires flexible conduits.



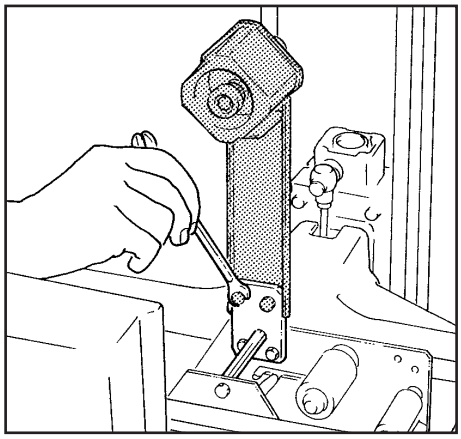
7.6 POSITIONING OF COLUMNS GUARDS

Install the columns guards as shown on Picture.



.7 POSITIONING OF THE TAPE HOLDER

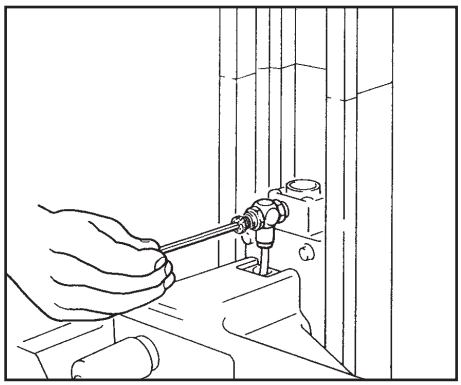
Take away the screws that hold the core holder bracket to the machine. Position the bracket as shown on Picture and lock the screws previously removed.

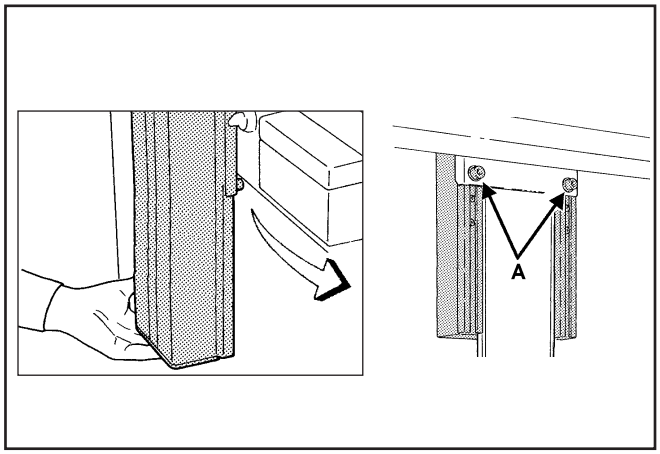


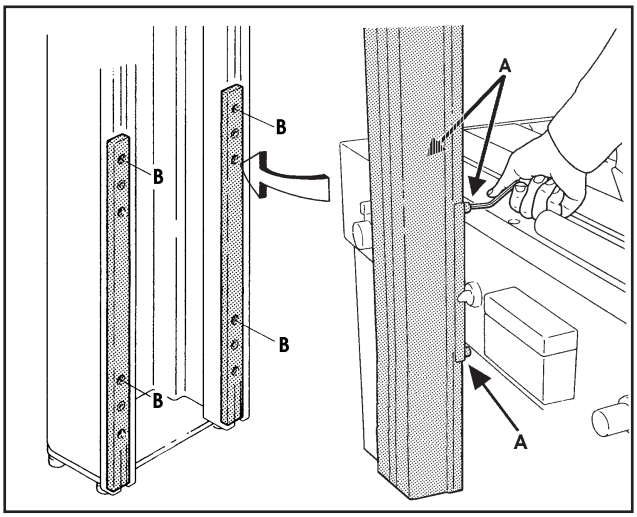
7.8 POSITIONING OF THE COLUMNS

Loosen the cap of the air cylinder.

Keep the column with one hand and take the two screws **A** away. Push upward the column so to position it near holes **B**. Take the other two screws supplied with the spare parts kit and fix the column (four screws each column).

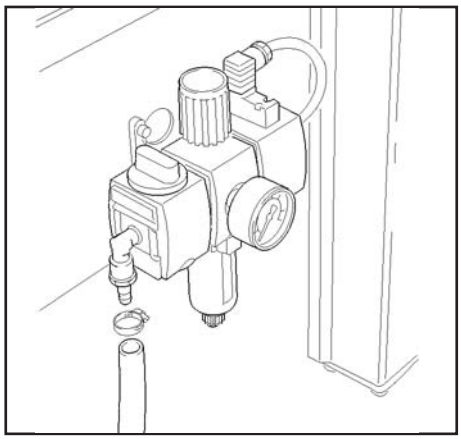




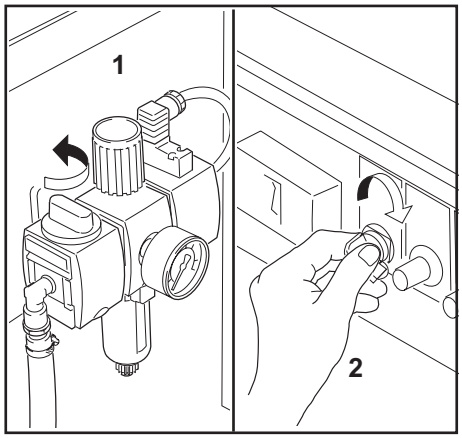


7.9 PNEUMATIC CONNECTION

Connect a 8 mm diameter hose to the plug and fix it by the supplied clamp.

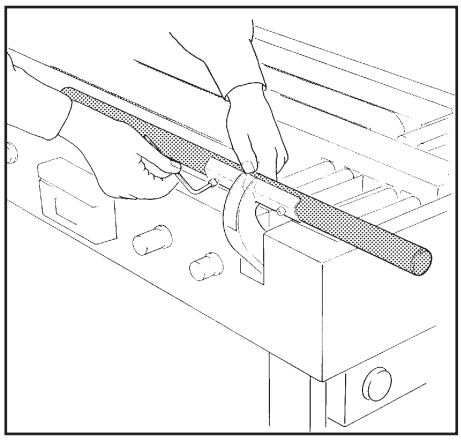


. Activate the pneumatic circuit by turning counterclock-wise knob **1** and raise the upper head by turning clockwise selector **2**. Remove the polystyrene blocks.



7.10 POSITIONING OF THE SIDE GUIDES

Mount the side guides on the centering levers as shown on Picture.



7.11 PRELIMINARY ELECTRIC CHECK-OUT

Before connecting the machine to the mains please carry out the following operations:

7.11.1 Make sure that the socket is provided with a ground protection circuit and that both the mains voltage and the frequency match the specifications on the machine plate.

7.11.2 Check that the connection of the machine to the mains meets the safety regulations in your country.

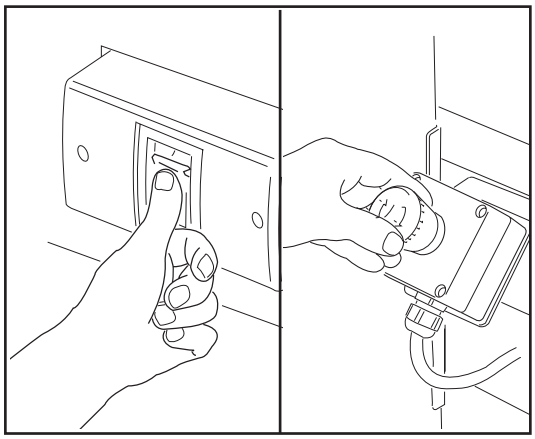
7.11.3 The machine is fitted with a main switch having a maximum breaking power of 6 kA and a short-circuit breaker pre-set at 120 A.
The user will be responsible of testing the short-circuit current in its facility and should check that the short-circuit amperage setting on the main switch of the machine is compatible with all the components of the mains system.

7.12 MACHINE CONNECTION TO THE MAINS AND CHECK-OUT

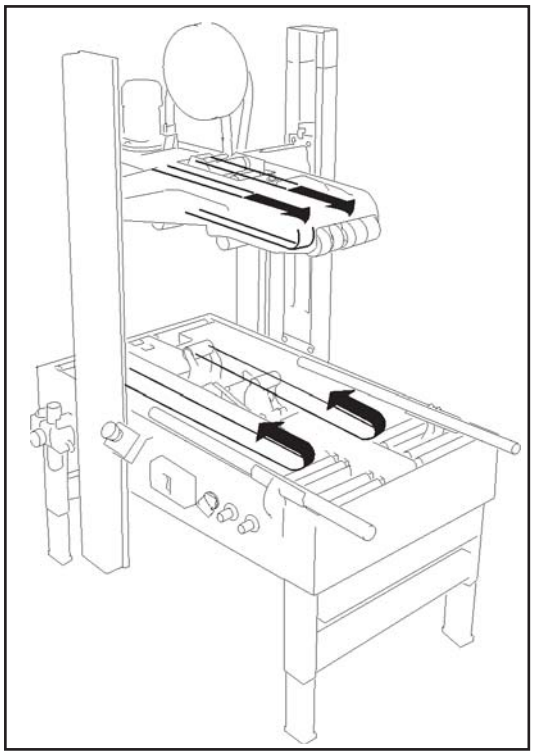
Power supply = 0,240 kW
Maximum breaking power of the main switch = 6 kA (230/400 V)
For technical features of the main switch: see section **15-ENCLOSURES**.
-Push the LOCKABLE EMERGENCY STOP BUTTON
-The magnetothermic main switch is normally turned OFF.
-Connect the cable supplied with the machine to a plug which complies with the safety regulations of your country.

7.13 CHECK-OUT OF PHASES (FOR THREE-PHASE MAINS ONLY)

Procedure to be followed in order to connect correctly the position of the phases:
-Remove any tools from the conveyor bed.
-Release the lockable emergency stop button turning it clockwise.
-Push button ON of the main switch.
-Check the rotation direction of the side drive belts.
-In case they rotate in the wrong way, please reverse 2 phases on the plug.

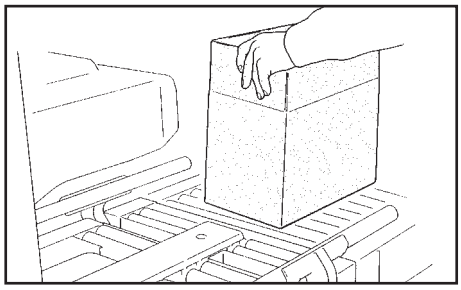


Correct rotation direction of the side drive belts.

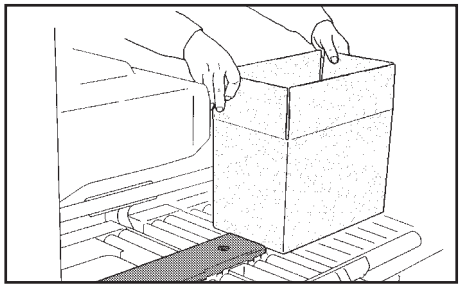


8.1 DESCRIPTION OF THE WORKING CYCLE

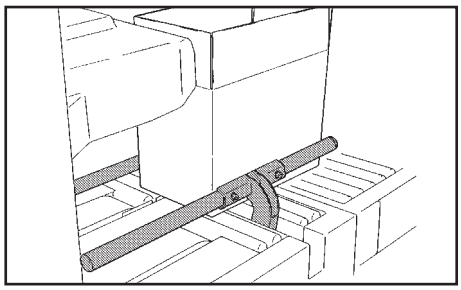
Fold manually the four lower flaps of the box.
Position the box, keeping the lower flaps folded, on the centering unit.



Keeping the box with the hands, make it advance until it presses the lever. This will approach the side guides to the box.

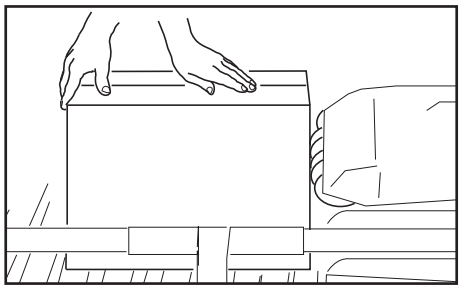


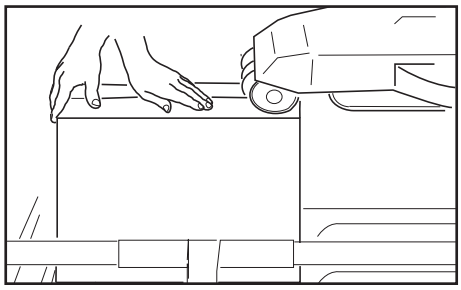
The side guides block the box on the centering unit, so that it can be filled without being hold with the hands.



After the filling fold the upper flaps and push the box against the lever which will start the uplifting of the taping unit.

Let the box pass through the machine up to reach the lower driving belts





8.2 OPERATING MODES

The case sealer Mod. SR46-S has only one automatic working mode, with:
-The EMERGENCY STOP BUTTON unlocked
- The start button pushed ON
- Pneumatic circuit activated.

8.3 HOW TO STOP THE MACHINE

8.3.1 NORMAL STOP PROCEDURE

When the main switch is turned OFF, the machine stops immediately at any point of the working cycle.
The same thing happens in case of electric black-out or when the machine is disconnected from the mains.
Air pressure remains ON.

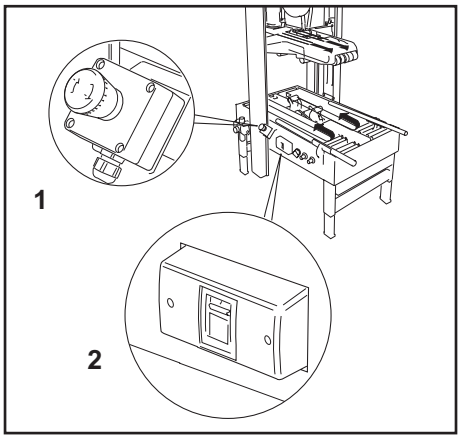
8.3.2 EMERGENCY STOP

The lockable button for emergency stop is located on the infeed side of the top head.
(This part is not produced by the machine manufacturer. For its technical specifications see section **15-ENCLOSURES**).

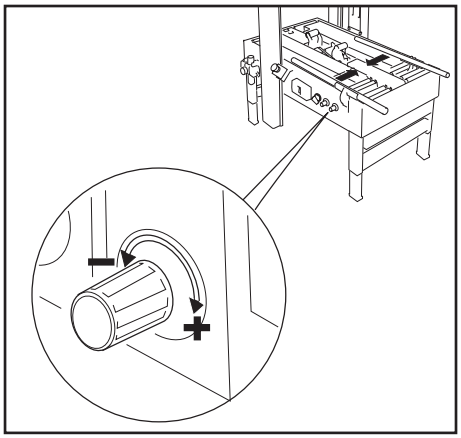
9-CONTROLS IN BRIEF

9.1 START/STOP BUTTON (2)
It starts/stops the box drive belts.

EMERGENCY STOP BUTTON (1)
It stops the machine cycle.

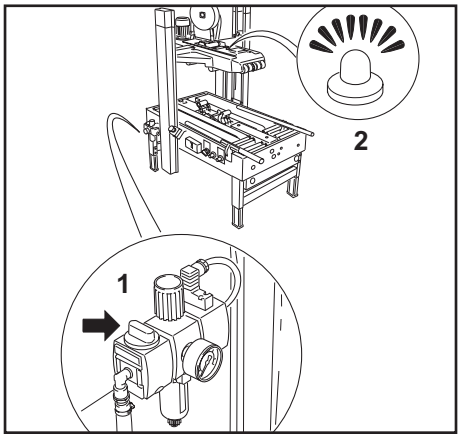


9.2 SIDE GUIDE PRESSURE ADJUSTMENT KNOB
It adjusts the pressure of side guides against the box.

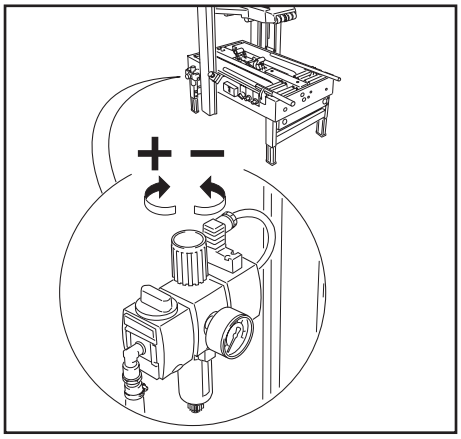


9.3 FEEDING VALVE FOR THE PNEUMATIC CIRCUIT (1)
Activates/desactivates the pneumatic installation.

AIR PRESSURE INDICATOR (2)
Shows the air presence in the circuit (red indicator is up).

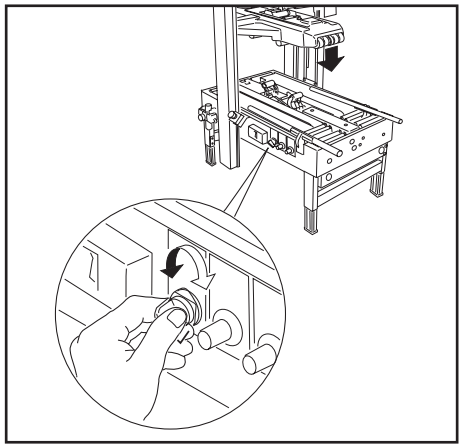


9.4 MANOPOLA REGOLAZIONE PRESSIONE IMPIANTO PNEUMATICO
Aumenta / diminuisce la pressione nel circuito.



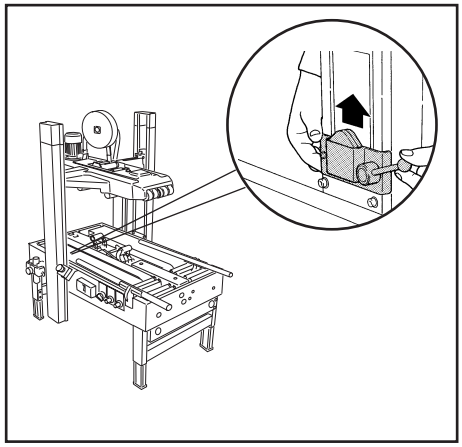
9.5 UP/DOWN SELECTOR

Raises or lowers the upper head assembly.



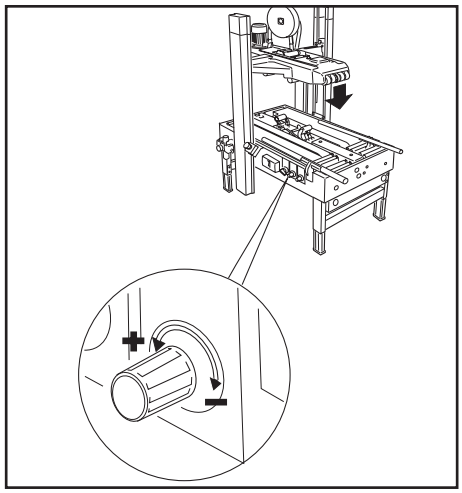
9.6 UPPER HEAD HEIGHT BLOCK

Is used to lock the upper head assembly according to the minimum box height.



9.7 UPPER HEAD PRESSURE ADJUSTMENT KNOB

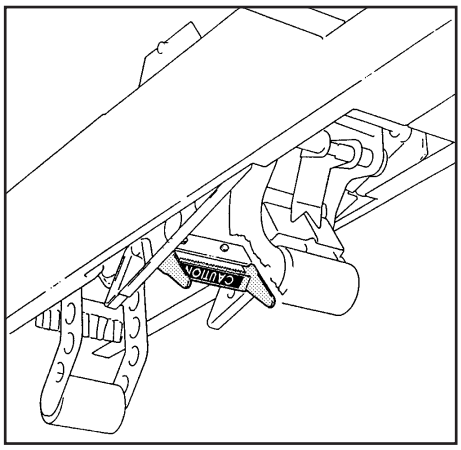
Increases / decreases the weight of the upper head assembly on the box.



10-SAFETY DEVICES OF THE MACHINE

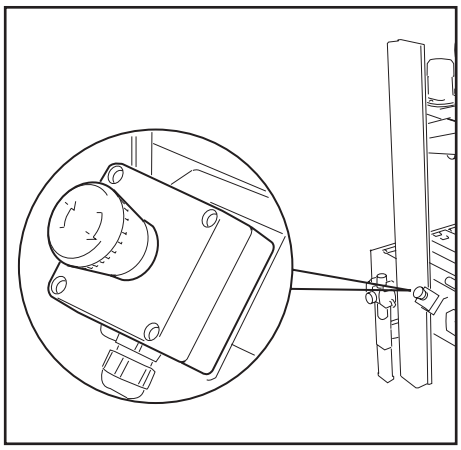
10.1 BLADE GUARDS

Both the top and bottom taping units have a blade guard.



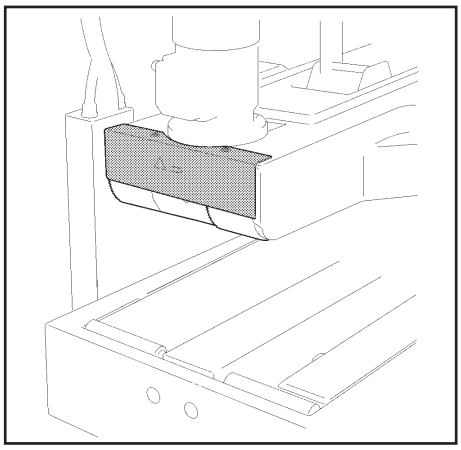
10.2 EMERGENCY STOP BUTTON

The lockable emergency stop button is placed in handy position.



10.3 METAL SAFETY GUARD

Safety guard of the top driving belts.

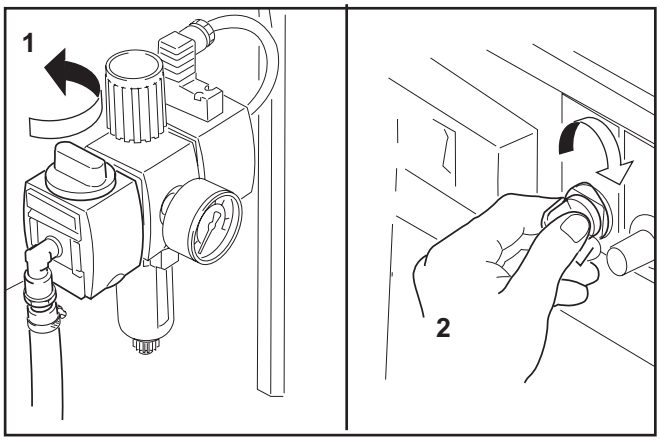


10.4 ELECTRIC SYSTEM

The electric system is protected by a ground wire whose continuity has been factory- tested during the electrical test. The system is also subject to insulation and dielectric strength tests.
(See section **ENCLOSURES 15.5**)

11.0 SAFETY

All the set-up operations and adjustments must be carried out when the machine is stopped and the EMERGENCY STOP BUTTON is locked.

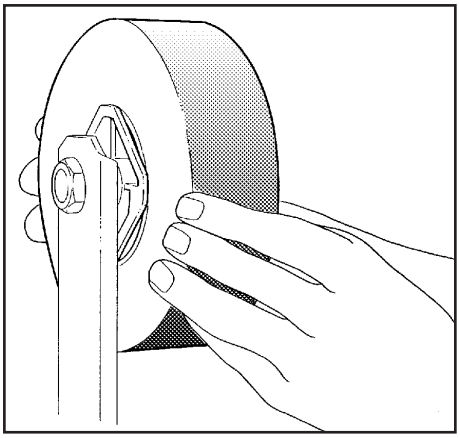


11.1 TAPE LOADING ON THE TOP UNIT

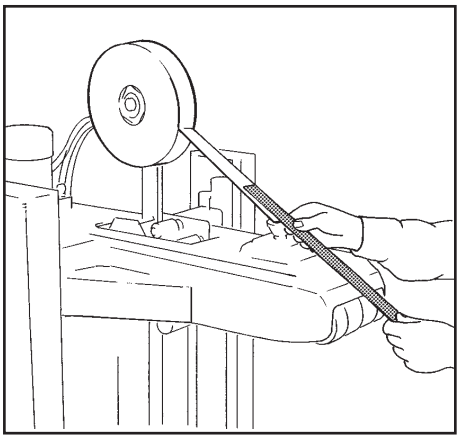
Turn the knob **1** to activate the pneumatic circuit and raise the upper head assembly by turning clockwise the selector **2**.

.

Insert a tape roll on the drum and push it fully forward.

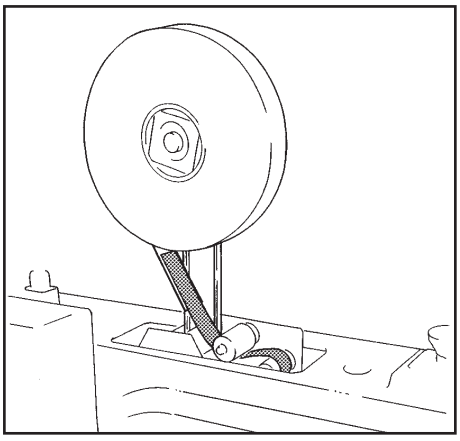


Attach the tape leg to the threading tool (supplied with the tools kit).

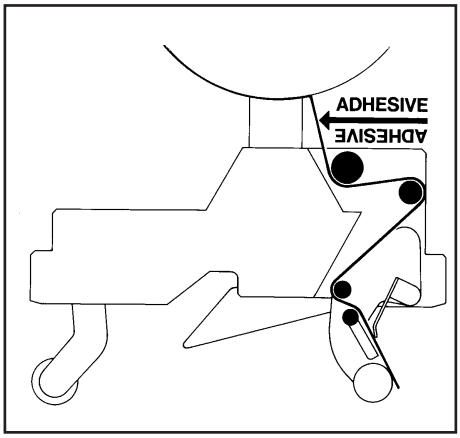


WARNING! Very sharp blade. It may cause serious injuries.

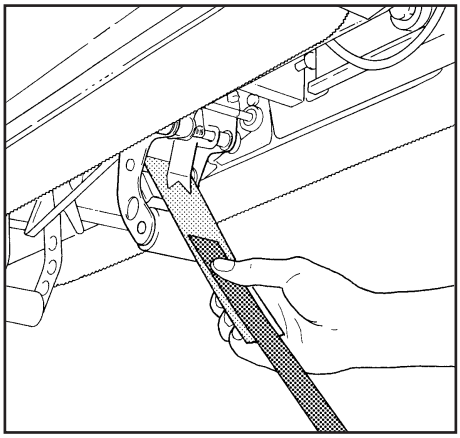
Insert the plastic threading leader through the taping unit. Take care to keep hands away from the tape cutting blades. (see section **3.11-g**).

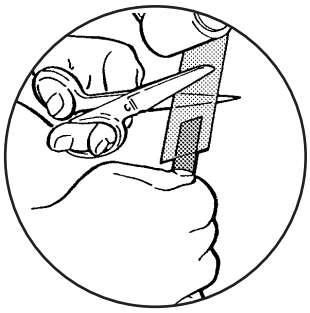


Follow the path through the unit as shown on Picture and make sure that the adhesive side is placed on the correct side.



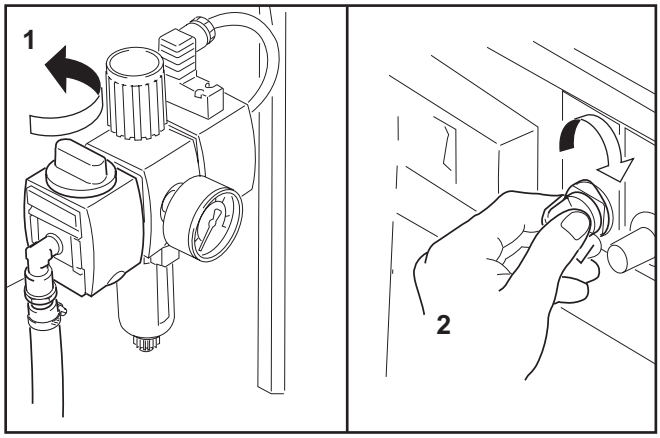
Pull and cut off the tape in excess.



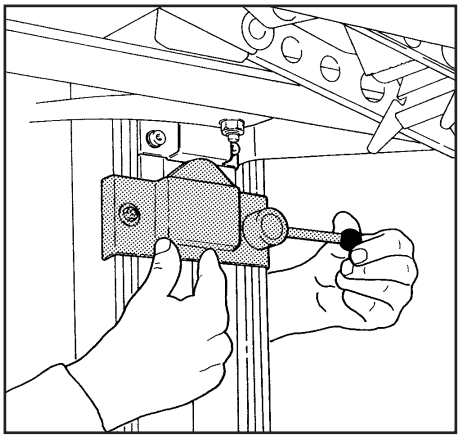


11.2 TAPE LOADING ON THE BOTTOM UNIT

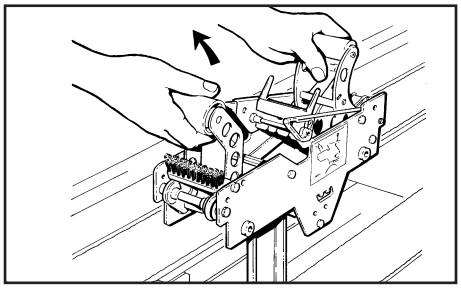
Turn the knob **1** to activate the pneumatic circuit and raise the upper head assembly by turning clockwise the selector **2**.



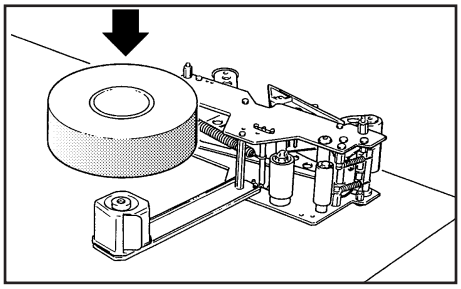
. Lift the lock against the upper taping head and clamp it with the lever. Once the tape has been replaced, bring the lock at its original position.



Remove the bottom taping unit from its housing and put it on a working bench.

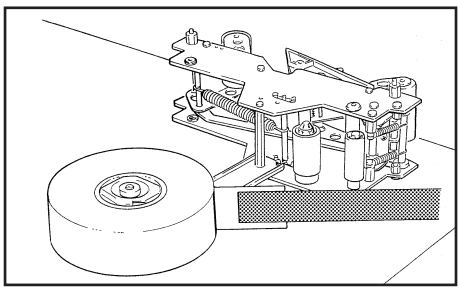


Put a tape roll on the drum.

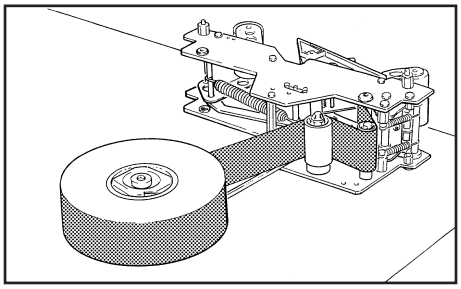


WARNING! Very sharp blade. It may cause serious injuries.

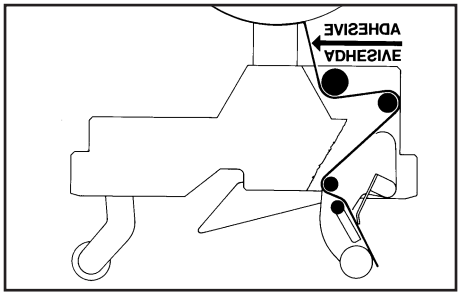
. Attach the tape leg to the threading tool (supplied with the tools kit).



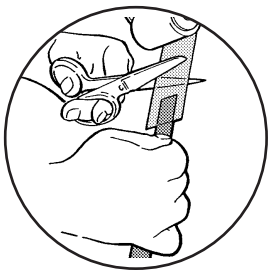
Insert the plastic threading leader through the taping unit. Take care to keep hands away from the tape cutting blades. (see section **3.11-g**).



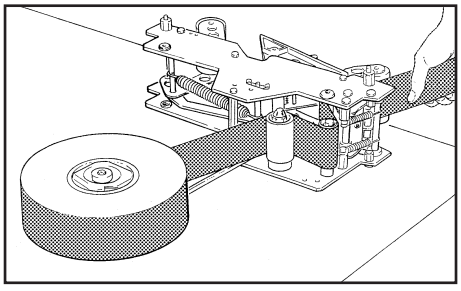
Follow the path through the unit as shown on Picture and make sure that the adhesive side is placed on the correct side.



Pull and cut off the excess tape.

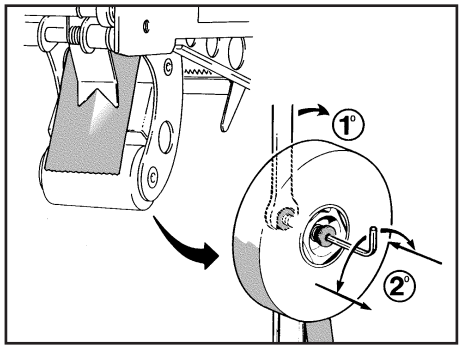


Put again the taping head into its seat..



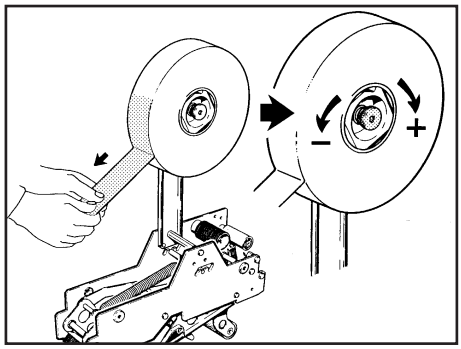
11.3 TAPE DRUM ALIGNMENT

Check the centering of the tape on the rollers of the taping unit.
If needed, unlock bolt **1** and adjust screw **2**.



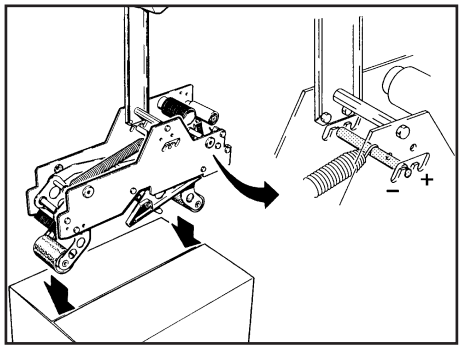
11.4 TAPE DRUM FRICTION BRAKE ADJUSTMENT

Check the tape tension:
- with PVC tape the drum must be free
- with OPP tape the drum must be slightly frictioned



11.5 ADJUSTMENT OF TAPING UNITS ACCORDING TO THE TYPE OF BOXES

Adjust the main spring:
- decrease the spring load for lightcardboard cases;
- increase the spring load for robustcardboard cases.



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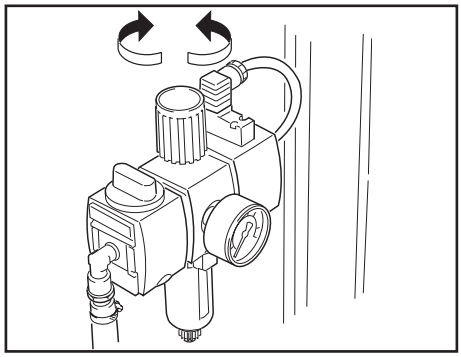
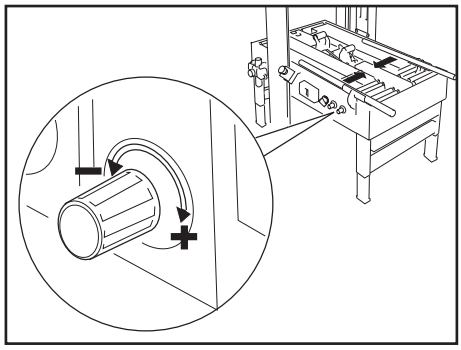
11.6 AIR PRESSURE REGULATOR

Adjust air pressure according to the cardboard thickness.
Max pressure 6 Bar.



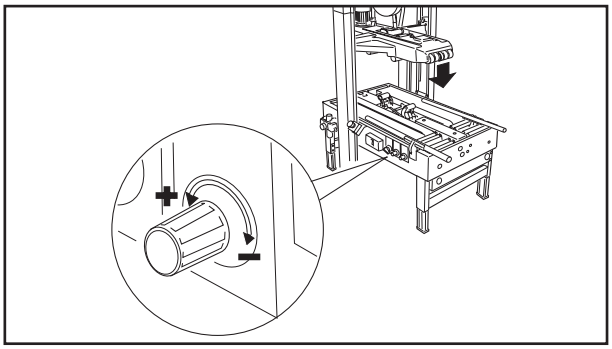
11.7 SIDE GUIDE PRESSURE

Decrease the pressure, for light cardboard cases.
Increase the pressure for robust cardboard case



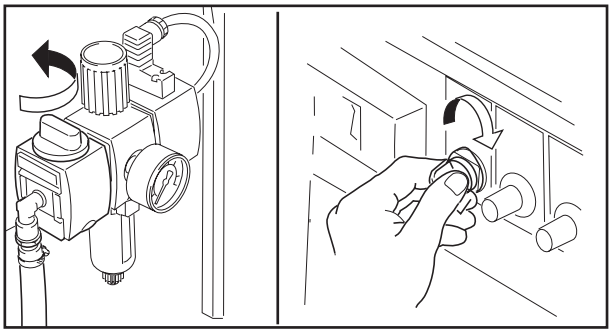
11.8 UPPER HEAD PRESSURE

Adjust the pressure of the upper taping unit on the box. Decrease or increase the air pressure according to the box weight.



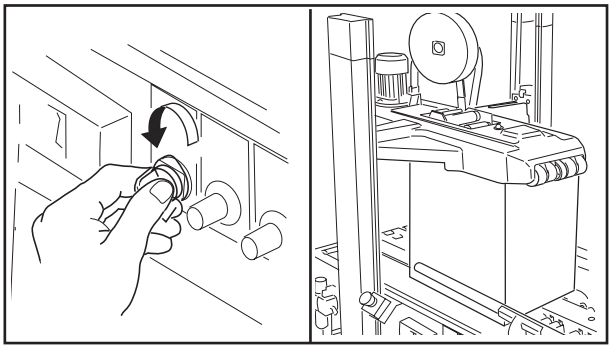
11.9 ADJUSTMENT OF THE UPPER HEAD DESCENT SPEED

In normal working conditions the upper had comes down up to the minimum height of 110 mm at the end of each sealing cycle.
It is possible to set a limit for the descent when:
a) boxes of different size have to be sealed and the minimum height is known.
b) a batch of boxes of uniform size has to be sealed and the production speed-up is required.

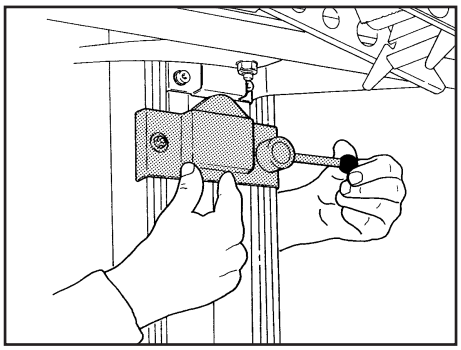


To adjust the minimum height of the upper head do as follows:

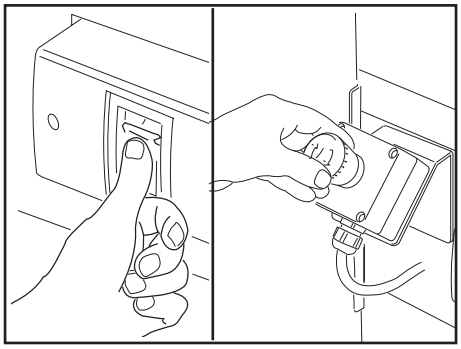
Turn the selector clockwise to raise the upper head assembly.
Insert the box to be sealed and rotate anticlockwise the selector to allow the upper head to come down on the box.



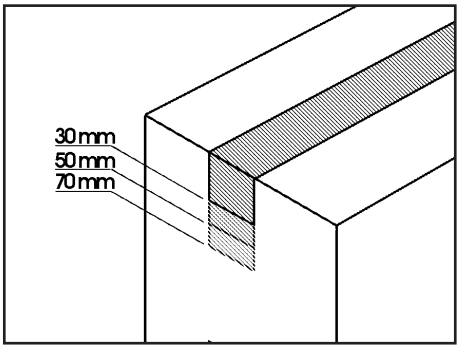
Bring the height stop against the upper assembly and lock it with the proper handle.



Turn clockwise the EMERGENCY STOP and press the ON button. The box will be dragged by the top and bottom belts, sealed and then driven out of the machine.



SPECIAL ADJUSTMENTS



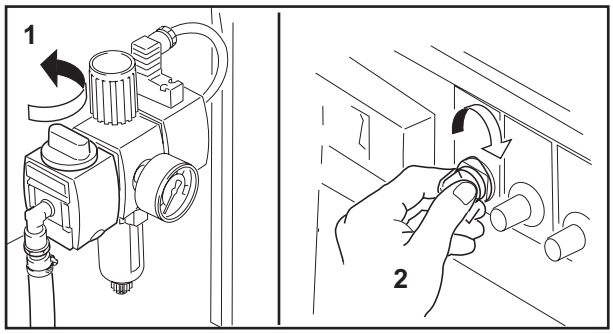
11.10 CHANGE OF THE TAPE LEG LENGTH

The tape leg length can vary from 70 to 50 to 30 mm. To adjust the tape leg length refer to the manual of the K12 taping unit, supplied with the machine.

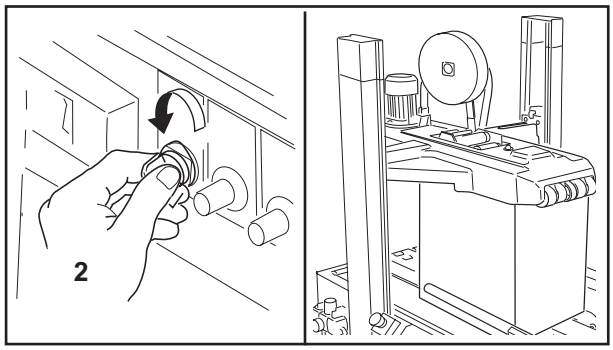
11.11 OUTER COLUMNS IN HIGH POSITION

To seal boxes higher than 750 mm it is necessary to raise the outer columns as follows:

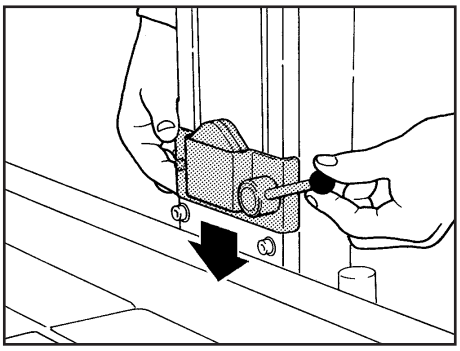
Activate the pneumatic circuit rotating anti-clockwise the knob **1** and lift the upper unit rotating clockwise the selector **2**.



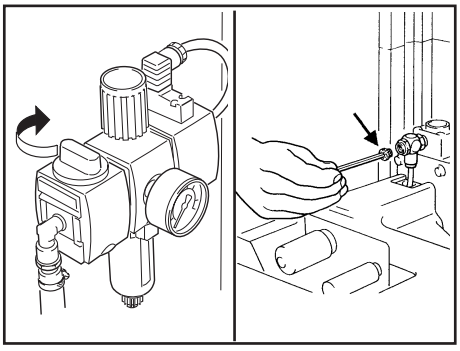
Insert under the upper head assembly a strong case or wooden box, rigid enough to support 45 kg, and approximately 450 mm high. Turn counter-clockwise the selector **2** so that the upper unit leans on the support.



Release the upper head stop and move it fully down.

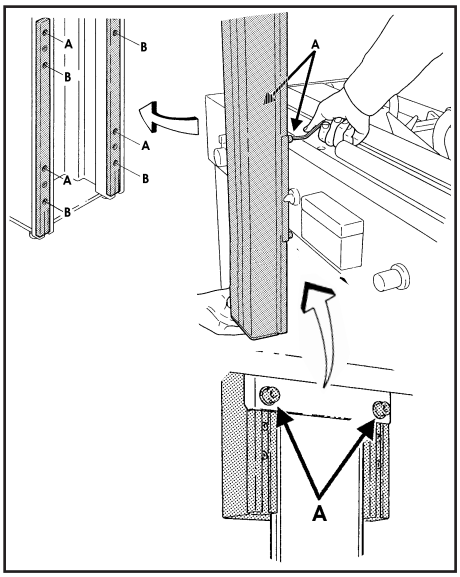


Cut the air pressure, rotating the knob clockwise.
Remove the air circuit cap. So that all the air in the circuit comes out.
Put the cap again in place.



Keep the outer column with one hand and remove the four screws **A** with the other hand; push the column up until it reaches the holes **B**. Reassemble and tighten the four screws.

Put the pneumatic installation back into work.

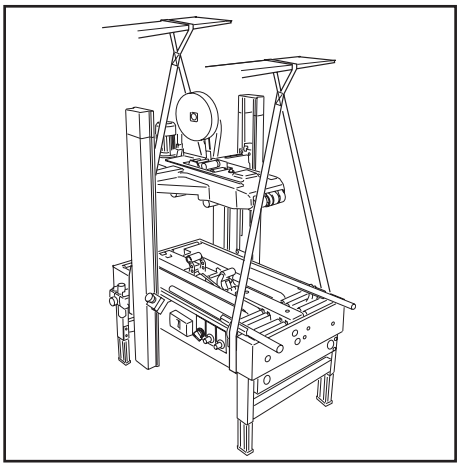


11.12 AS77 CASTERS (OPTIONAL)

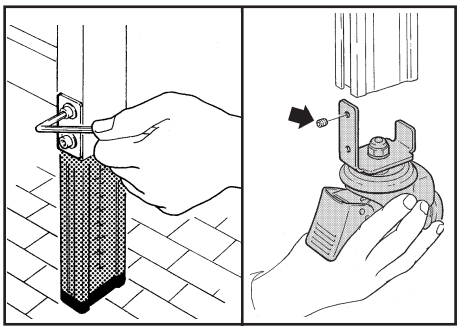
(code nr. 7.8.04337.00B)

To make easier the machine displacement, it is possible to fit the optional casters. Doing this, the conveyor bed height and the machine overall dimensions change (see section 4.7).

Lift the machine as shown on Picture.



Remove the pad-feet, insert the casters fixing them with the two dowels and set the desired conveyor bed height (refer to the graduated leg label).
(Caster height = 100 mm-4 inch).

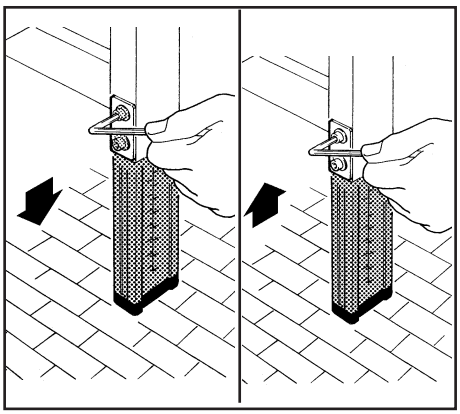


11.13 AS80 LEGS (OPTIONAL)

(Kit code nr. 7.8.04413.00A)

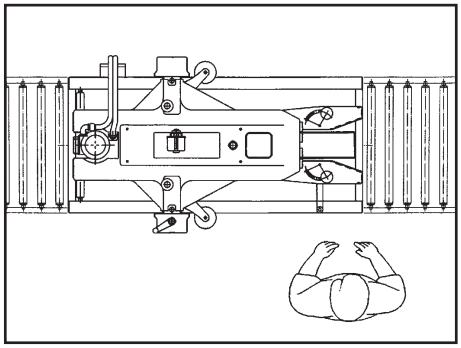
To obtain a higher range of conveyor bed height as indicated at section 4.7, it is necessary to replace the inner legs with the longer AS80 legs.

Uplift the machine as shown on Picture.
Unlock the screws and take out the legs.Insert the new legs and block them at the desired height.



12-OPERATION

12.1 OPERATOR'S CORRECT WORKING POSITION



12.2 STARTING THE MACHINE

Push the main switch ON.

12.3 STARTING PRODUCION

After having adjusted the machine according to the box dimensions (height-width), let the machine idle for a while and check its safety devices (see section **12.8**). Then start the working cycle.

12.4 TAPE REPLACEMENT

Be careful with the blades !

Skill **1** operator

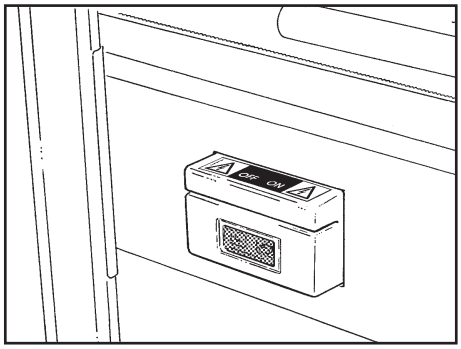
When needed, replace the tape roll, as follows:

-Press the LOCKABLE EMERGENCY STOP BUTTON;

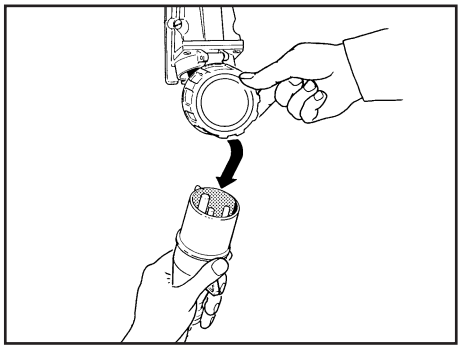
-Repeat all the operations shown in sections **11.1** and/or **11.2**

12.5 CLEANING

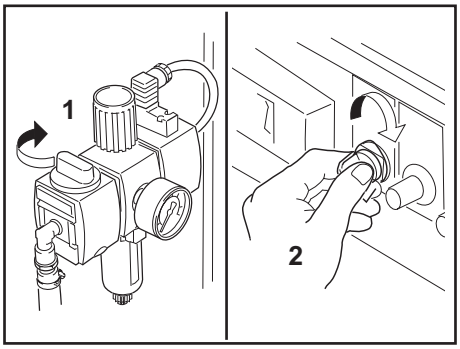
Before carrying out any cleaning or maintenance operation stop the machine by pressing the OFF button on the main switch.



Disconnect the electric power.



Activate the pneumatic circuit rotating counter-clockwise the knob **1** and lift the upper head assembly by rotating clokwise the selector **2**. Lock the upper head with the height stop (see section 11.2).



CLEANING - Skill **1** operator

Use dry clothes or light detergents.

Do not use solvents or water jets.

12.6 TABLE OF ADJUSTMENTS

OPERATIONS	OPERATOR'S SKILL	SECTIONS
Tape loading	**1**	**11.1 - 11.2**
Tape alignment	**1**	**11.3**
Checkout of the safety devices	**1**	**12.7**
Adjustment of tape drum friction brake	**1**	**11.4**
Adjustment of the upper head descent speed	**1**	**11.9**
Adjustment of tape applying spring	**1**	**11.5**
Conveyor bed height adjustment	**1**	**7.4**
Air pressure	**1**	**11.6**
Special adjustment: Tape leg	**2**	**11.10**
Special adjustment: Outer column in high position	**2**	**11.11**

12.7 SAFETY DEVICES CHECKOUT

1 Taping units blade guard (section 10.1)
2 Lockable emergency stop button (section 10.1)
3 STOP (OFF) button on main switch (sections 7.11.3 and 9.1)

12.8 TROUBLE SHOOTING

TROUBLE	CAUSE	SOLUTION
When pressing the ON button, the machine does not start.	The lockable emergency stop button is pressed. Short circuit in the electrical system.	Release the emergency stop button by turning it anticlockwise. Check the electrical system.
The magnetothermic protection opens the main switch.	Motor under stress . Thermal cut-out not at correct amperage setting.	Check that the drive belts are not blocked Set the correct amperage.
The motor runs but the side drive belts stop.	Belts tension too low. Worn out drive pulleys.	Adjust belt tension. Check the wear of the rings and replace them when necessary.
Drive belts turn but do not convey the box. The upper taping head does not descend or descend too slowly quickly.	Worn out belts Rise/descent selector non activated. The manufacture setting-up has been altered.	Replace drive belts. Turn in anticlockwise direction. Set the air pressure.

13-MAINTENANCE AND REPAIRS

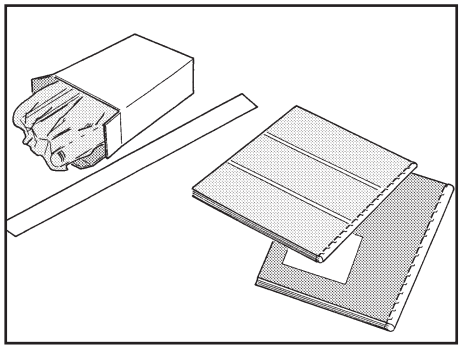
13.0 SAFETY MEASURES

(see section **3**)

Carrying out maintenance and repairs may imply the necessity to work in dangerous situations. This machine has been designed making reference to the standards EN292 NOV. 92/6.1.2 and EN292/2 NOV. 92/5.3.

13.1 SPARE PARTS SUPPLIED WITH THE MACHINE

1 N.1 blade (spare blade for taping unit, cod. S4004152ZZZ);
N.1 lower head spring (cod. S370017992Z);
N.1 upper head spring (cod. S370017894Z);
N.2 cutter spring (cod. S37022794Z);
2 Tape threading tool (to feed the tape through the taping unit) cod. S310091406Z
3 Instructions manual of the machine (cod. SMB00049K)
4 Instructions manual of the taping unit (cod. S300024296A0)



13.2 RECOMMENDED FREQUENCY OF CHECK-OUTS AND MAINTENANCE OPERATIONS

OPERATIONS	FREQUENCY	OPERATOR'S SKILL	SECTION
Lubrication	Quarterly	**2**	**13.5-6-7**
Blade cleaning	Weekly	**2**	**13.8**
Machine cleaning	Weekly	**1**	**12.5**
Checkout of safety devices	Daily	**1**	**13.4**
Blade replacement	//	**2**	**13.9**
Side drive belts replacement	//	**2**	**13.10**

13.3 CHECK-OUT TO BE PERFORMED BEFORE AND AFTER EVERY MAINTENANCE OPERATION

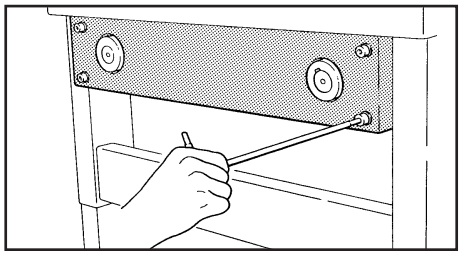
Before every maintenance operation press the OFF button on the main switch and disconnect the plug from the control panel.
During the maintenance operation only the operator responsible of this duty must work on the machine.
At the end of every maintenance operation check the safety devices.

13.4 SAFETY DEVICES CHECK-OUT

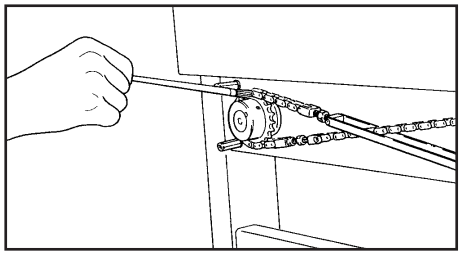
1 Taping units blade guard (section 10.1)
2 Lockable emergency stop button (section 10.1)
3 STOP (OFF) button on main switch (sections 7.11.3 e 9.1)

13.5 MACHINE LUBRICATION

Take the cover away.

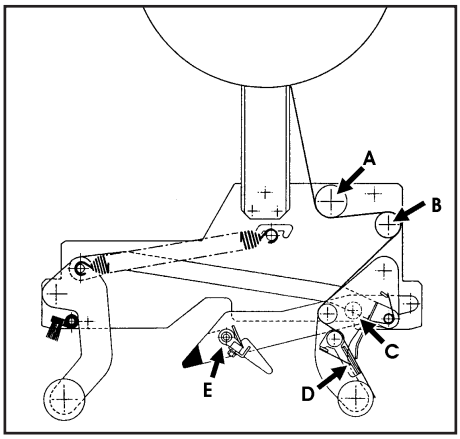


Lubricate the chain and the sprockets quarterly with grease metal/metal.



13.6 SUGGESTED PRODUCTS FOR LUBRICATION

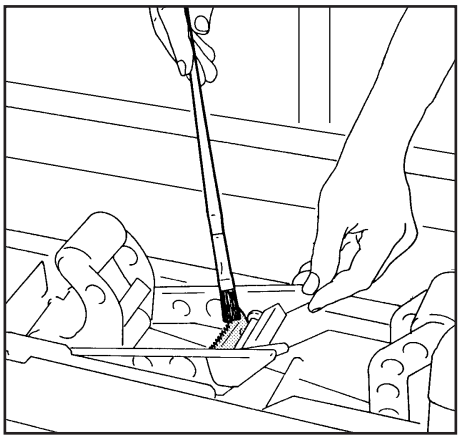
GREASE TYPE:
METAL/METAL: B.C.190 HEAVY DUTY (otherwise grease for chains and bearings)
METAL/PLASTIC: PLATE MASTER M+L (molybdenum grease and PTFE for plastic and metallic materials)
OIL TYPE:
regular lubricating oil or general purpose spray lubricant.



13.7 LUBRICATION OF THE TAPING UNIT

Lubricate monthly with oil the points shown on Picture.

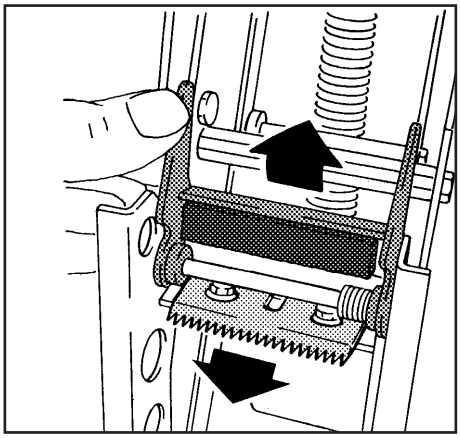
A spring holder pin
B spring tension pin
C roller shaft
D cutter hinge
E blade guard pin



13.8 BLADE CLEANING

Skill ***2*** operator
Lift the blade guard and clean the blade by using a brush (with a long handle) and some oil. The oil prevents the adhesive clotting.

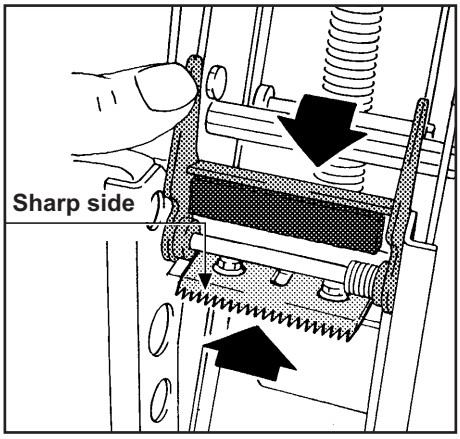
13.9 BLADE REPLACEMENT



Skill **2** operator
- Lift the blade guard as shown in Picture
- Release the screws.
- Remove the blade.

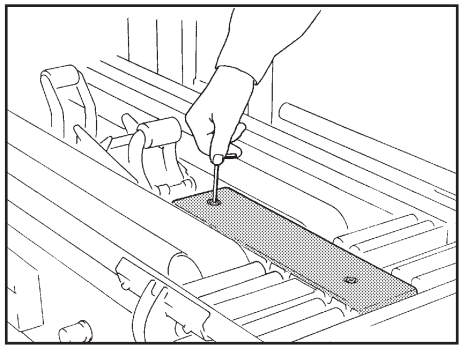
WARNING!
Very sharp blade.
Any error may lead to bad injuries.

- Insert the new blade paying attention to the position of its sharp side.
- Fix the screws.
- Release the guard..

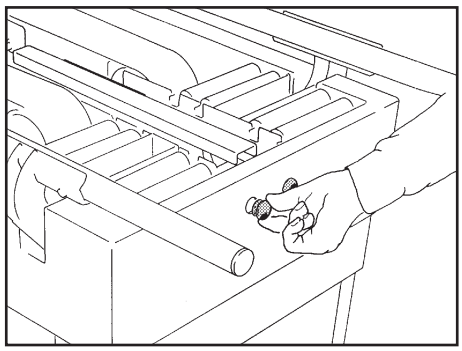


13.10 BOTTOM DRIVE BELTS REPLACEMENT

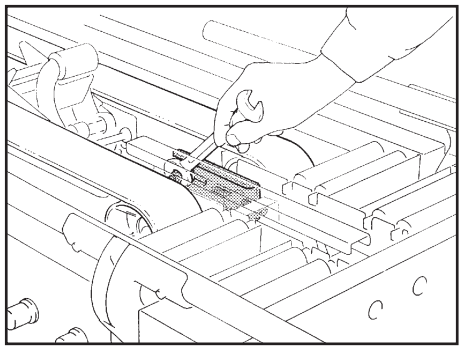
Skill **2** operator
- Remove screws.
- Take the protection cover away.



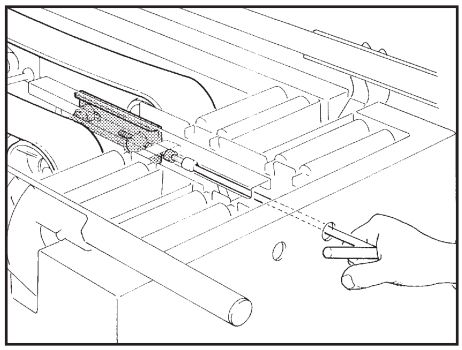
-Take the two caps away.



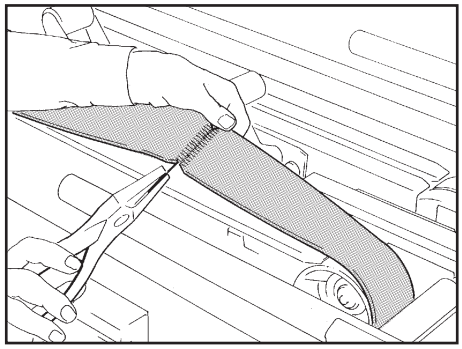
Loosen the locking nut.



Loosen the tensioning screw.



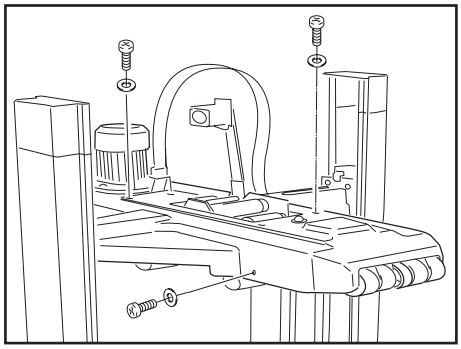
- Cut the worn belt.
- Position the new belt.
- Insert between the lace a nylon hinge.
- Adjust the belt tension.



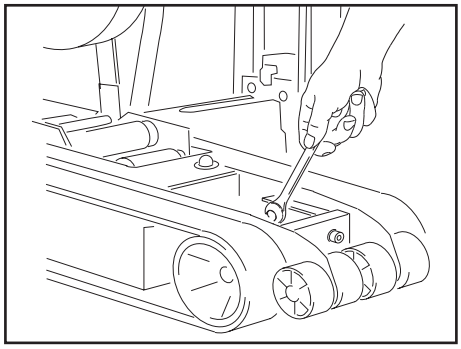
13.11 TOP DRIVE BELTS REPLACEMENT

Skill **2** operator

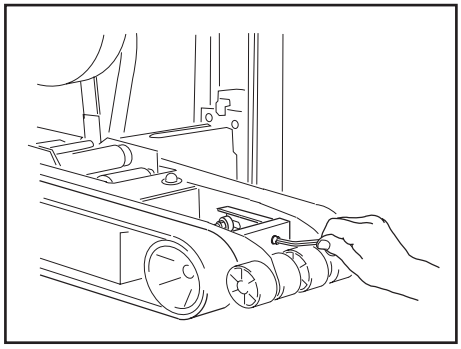
Remove the ten screws that hold the carter and take it out.



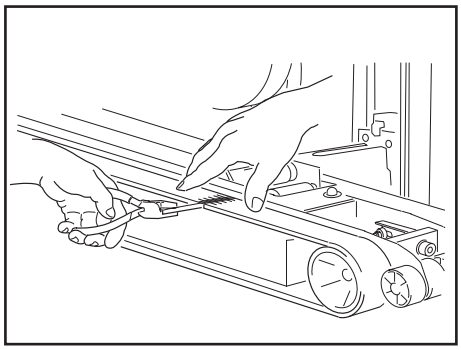
Loosen the locking nut.



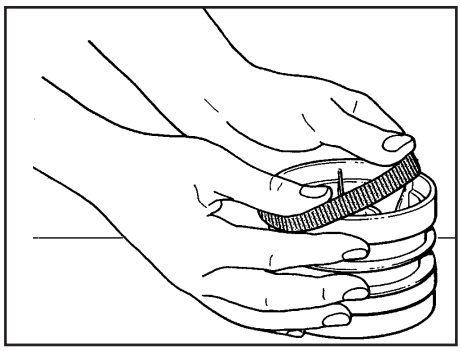
Loosen the tensioning screw.



- Cut the worn belt.
- Position the new belt.
- Insert between the lace a nylon hinge.
- Adjust the belt tension.

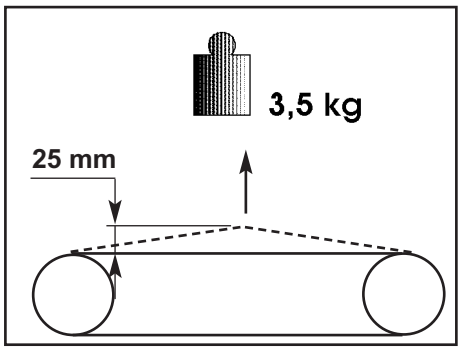


WARNING!
Before setting the new belt, check the wear of the orange plastic rings on the drive pulleys: replace them if they are worn out.

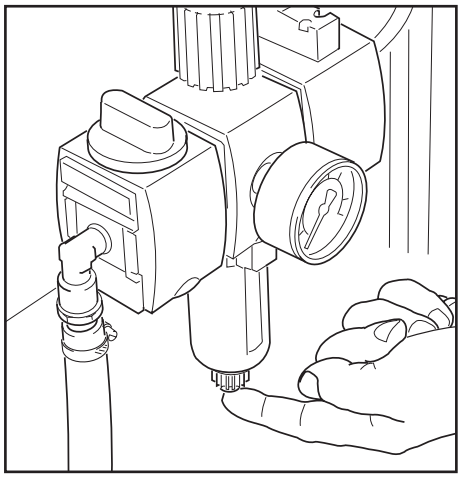


13.12 ADJUSTMENT OF THE BELTS TENSION

Check the tension of the belt by pulling it outwards in the middle.
A force of 3,5 kg should produce a gap of 25 mm (1 inch) betwen the belt and the frame



IMPORTANT!
Each time condensation accumulates in the filter, remove it by slightly pressing the bottom part of the cup as shown on Picture.



LIST OF THE MAINTENANCE IOPERATIONS CARRIED OUT ON THE MACHINE

Date	Decsription of operation

14-ADDITIONAL INSTRUCTIONS

14.1 INSTRUCTIONS FOR SCRAPPING AND DISPOSAL OF THE MACHINE

The machine is made of the following materials:

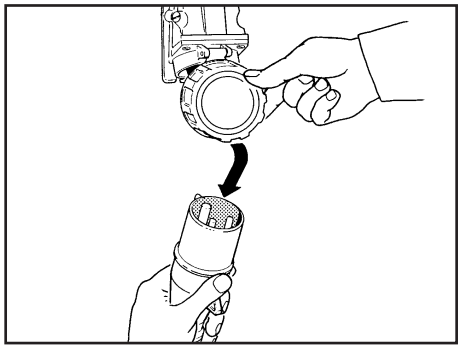
- steel frame
- nylon conveyor rollers
- PVC drive belts
- nylon pulleys

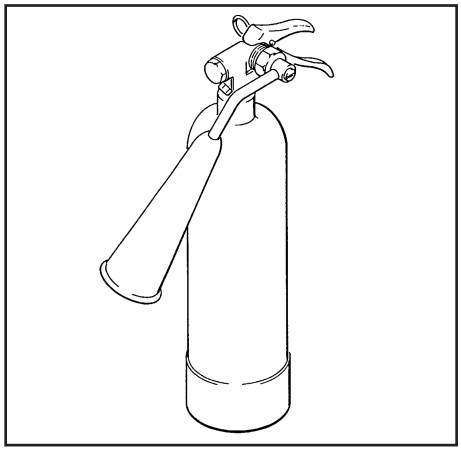
In order to dispose of the above materials please comply with the law in force in your country.

14.2 INSTRUCTIONS ON EMERGENCY SITUATIONS

ISTRUZIONI PER SITUAZIONI DI EMERGENZA

In case of danger/fire:
disconnect the electric power.





FIRE

In case of fire use an extinguisher containing CO2.

DO NOT use water.

15-ENCLOSURES

15.1 STATEMENT OF CONFORMITY

to the Directives on Machinery EEC 98/37, 91/368, 93/44 and 93/68.

15.2 SAFETY LABELS

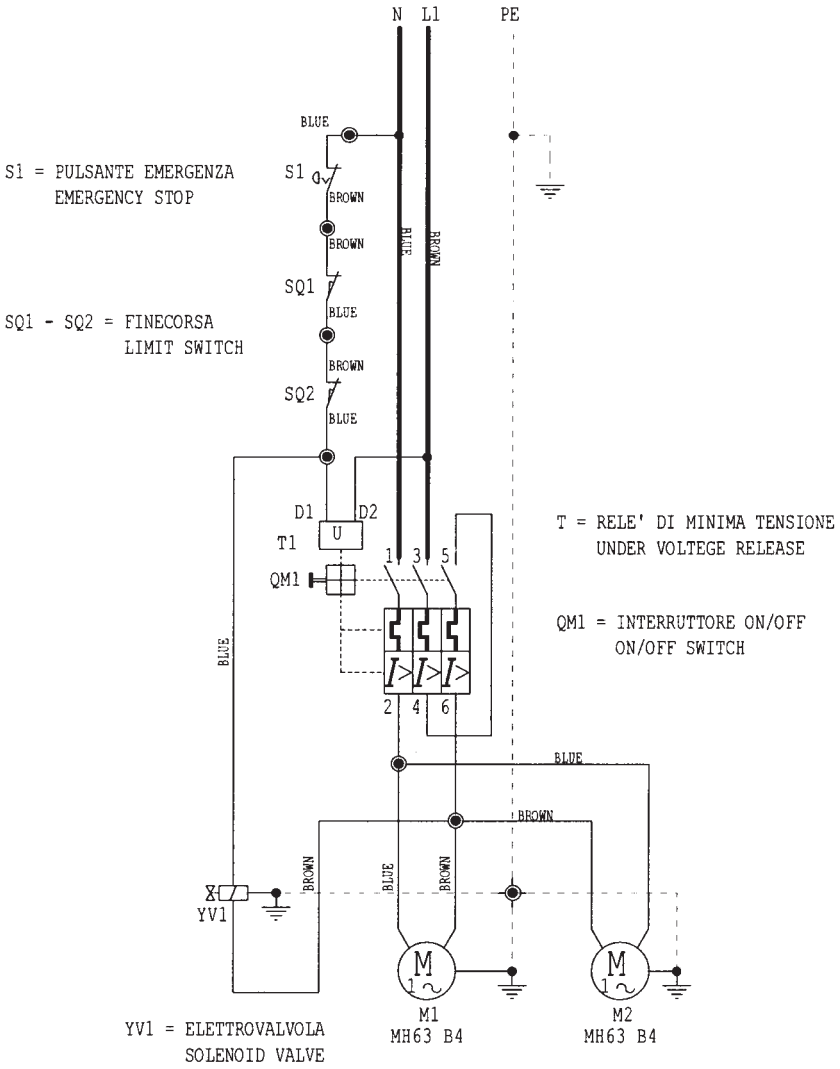
The safety labels are important for the correct use of the machine.
In case any label is damaged or removed, it is responsibily of the user to replace it immediately.
To order replacement labels, please refer to the article codes shown on **Figure 5709** in the spare parts catalogue.

15.3 EMISSIONS OF RADIATIONS, GAS, VAPOURS AND DUST

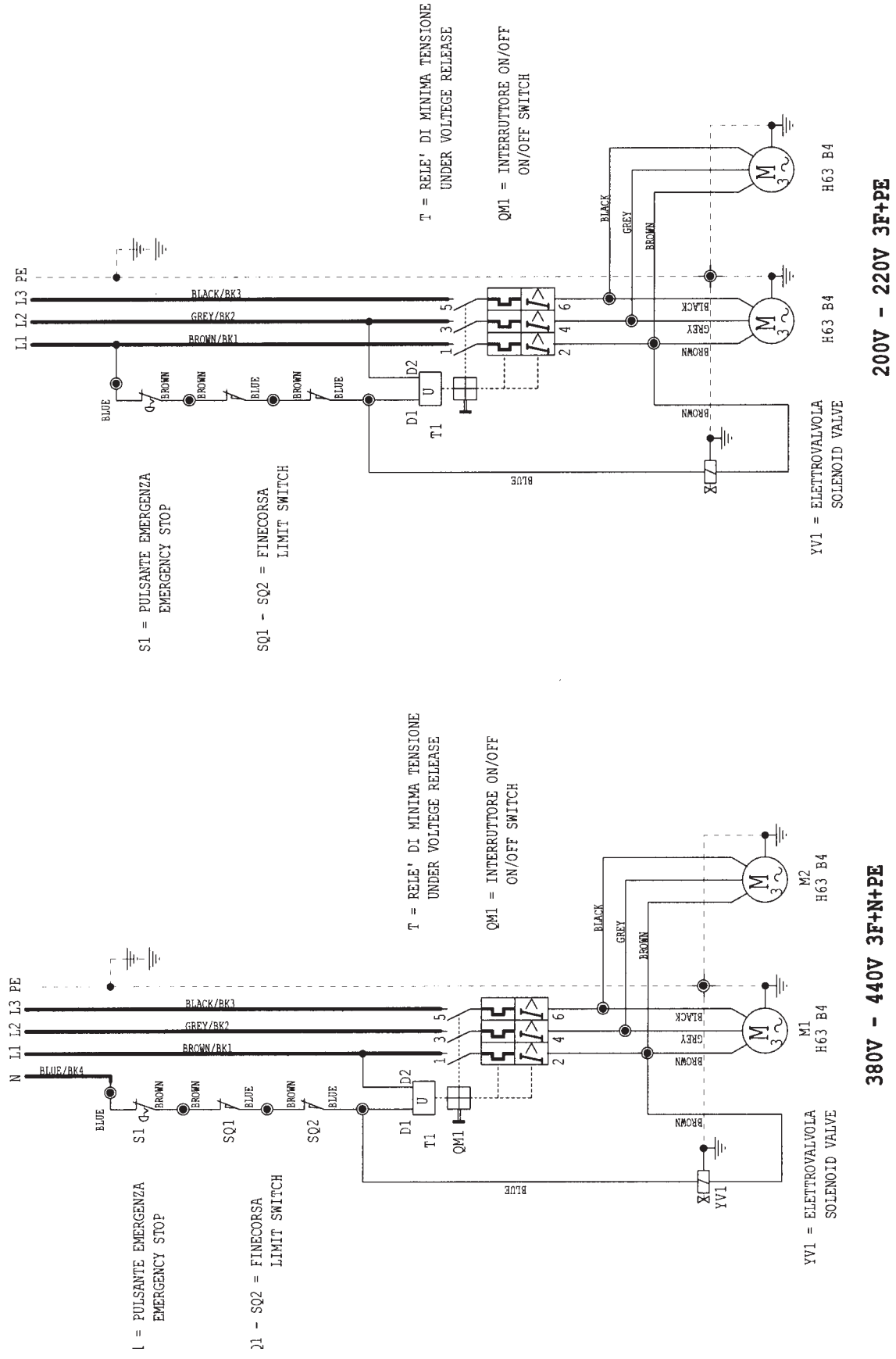
Nothing to report

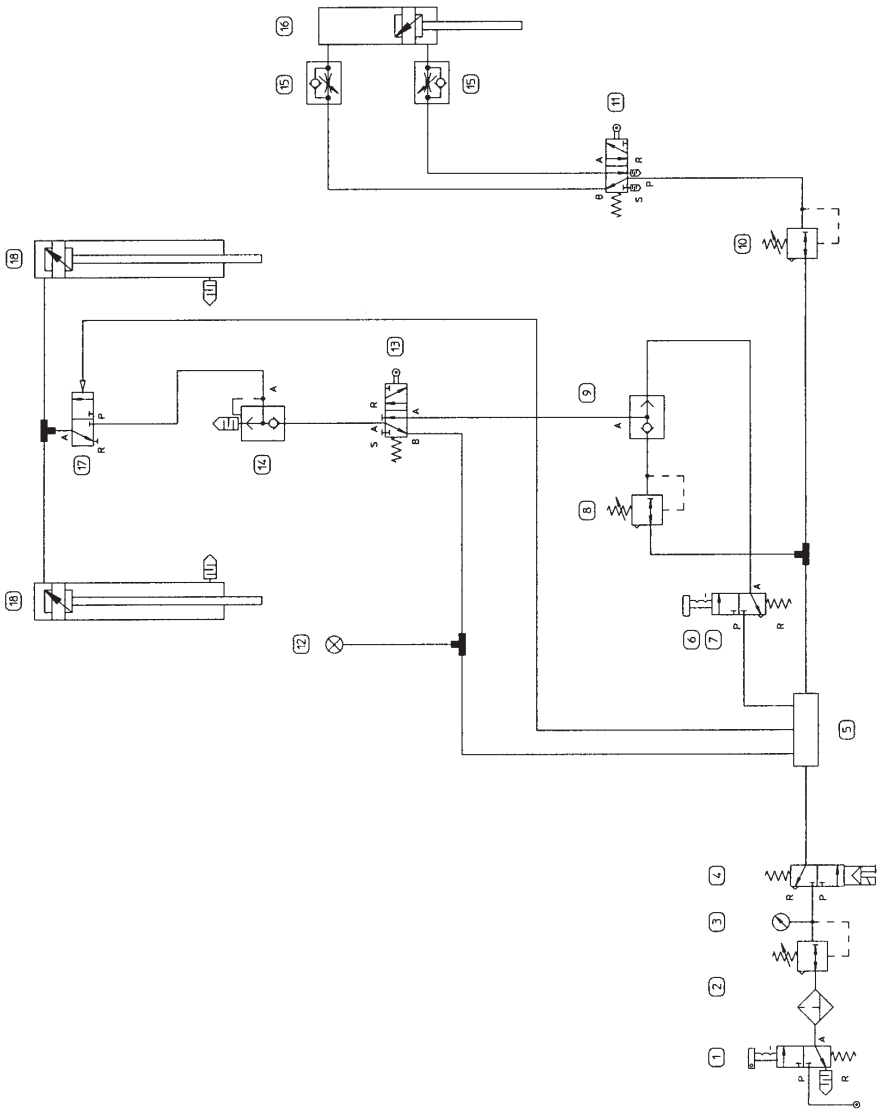
15.4 ELECTRIC TESTS

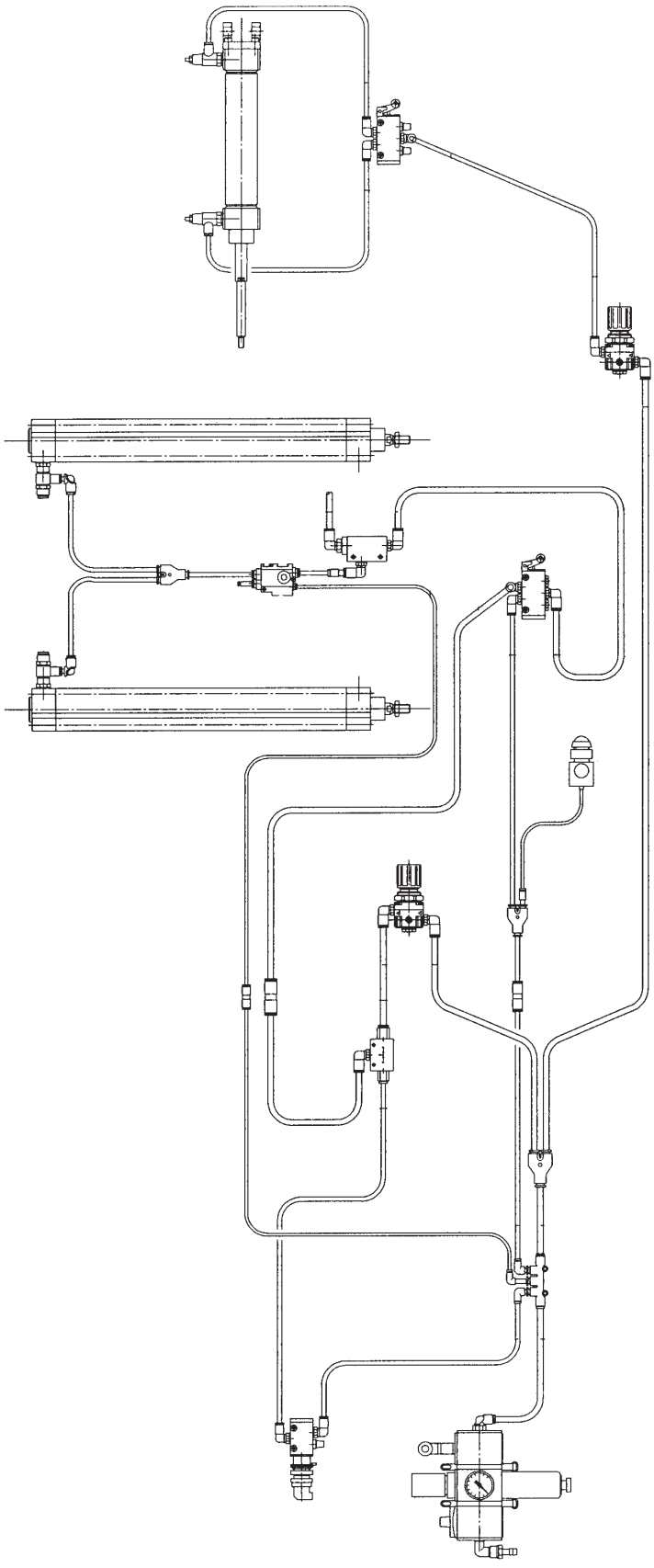
Electric tests:
1 - Continuity of the ground circuit
2 - Insulation resistance
3 - High voltage insulation
Reference: EN 60204-1 Section 20.2, 20.3, 20.4



100V - 240V MF+PE


200V - 220V 3F+PE
L1 L2 L3 PE
BLACK/BK3
GREY/BK2
BROWN/BK1
T = RELE' DI MINIMA TENSIONE
UNDER VOLTEGE RELEASE
QM1 = INTERRUTTORE ON/OFF
ON/OFF SWITCH
S1 = PULSANTE EMERGENZA
EMERGENCY STOP
SQ1 - SQ2 = FINECORSA
LIMIT SWITCH
YV1 = ELETTROVALVOLA
SOLENOID VALVE
H63 B4
380V - 440V 3F+N+PE
N L1 L2 L3 PE
BLUE/BK4
M1
M2





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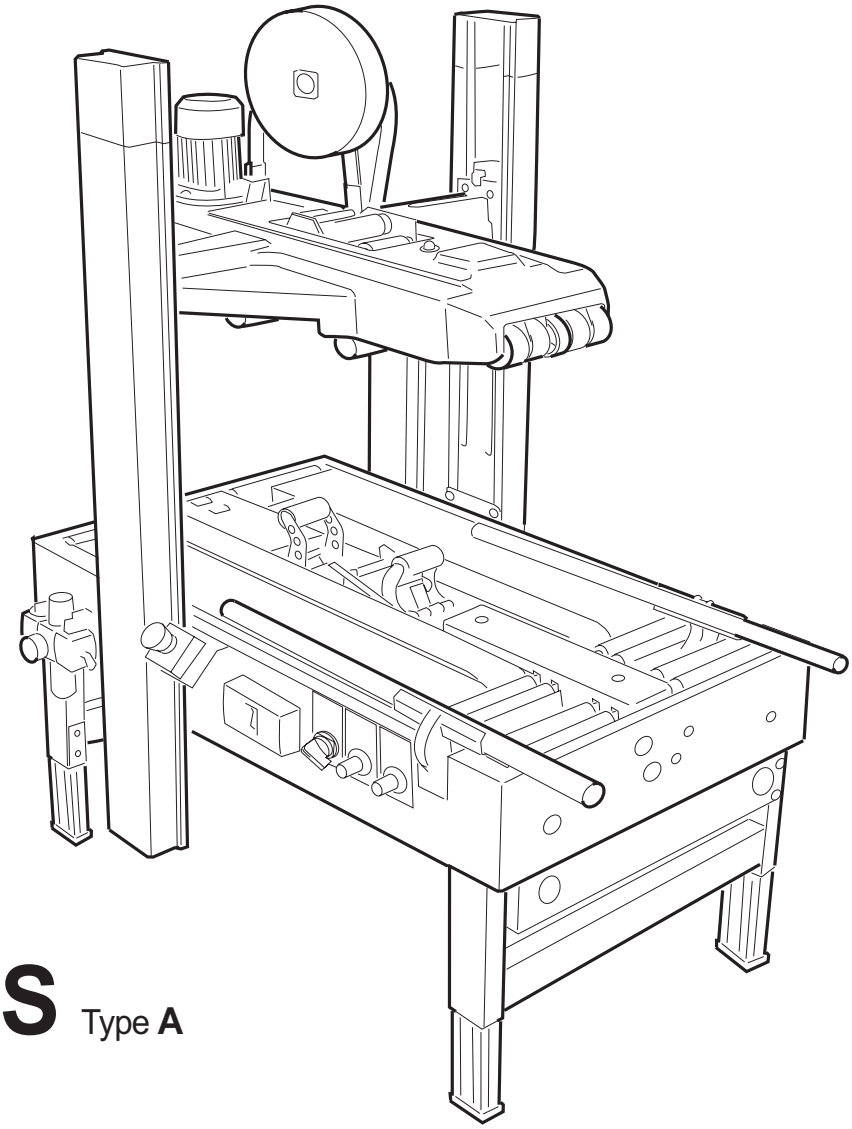

SR46-S Type **A**

NASTRATRICE AUTOMATICA
AUTOMATIC CASE SEALING MACHINE
MACHINE ENRUBANNEUSE AUTOMATIQUE
AUTOMATISCHE KARTONVERSCHLIESSMASCHINE
PRECINTADORA AUTOMATICA

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO
INSTRUCTIONS MANUAL AND SPARE PARTS LIST
MANUAL D'INSTRUCTIONS ET PIECES DETACHEES
BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE
MANUAL DE INSTRUCCIONES Y RECAMBIOS

CE

Code publication.: SMB00049K

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Manuel d'instructions pour l'utilisation, les dispositifs de sécurité, l'entretien et les pièces de rechange de l'enrubaneuse SR4-S Type A.

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Edition Janvier 2007

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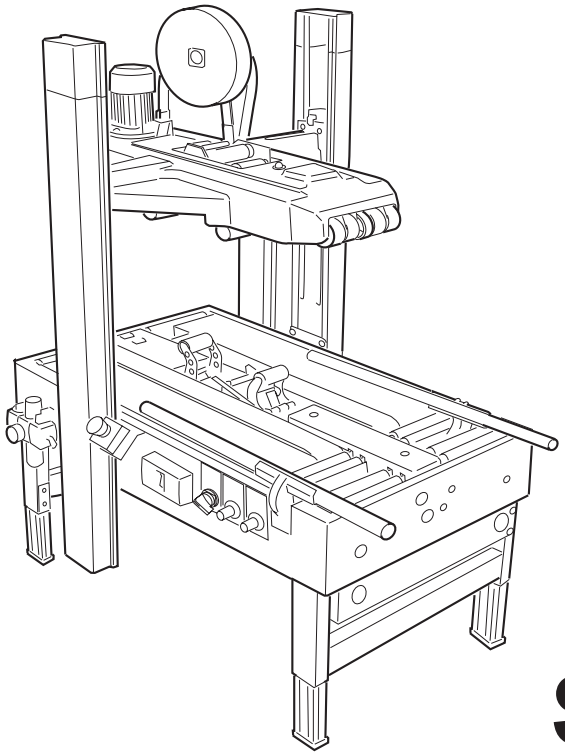
Le constructeur se réserve le droit d'apporter des modifications à la machine sans préavis

Publication n° SMB00049K
Version I



SR46-S Type **A**

MACHINE ENRUBANNEUSE AUTOMATIQUE AUTOREGLABLE A COURROIES D'ENTRAINEMENT SUPERIEURES ET INFERIEURES

- Dimensions maximum de la boîte h. 750 mm x w. 650 mm
- Ruban adhésif de 75 mm
- Vitesse de deplacement des boîtes 22 m/minute
- Production moyenne 650 boîtes/heure

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Sécurité	3
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Données techniques	4
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Déballage	6
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Fonctionnement	8
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Pièces de rechange	voir en fin de manuel

ABREVIATIONS ET SIGLES

ABREVIATIONS, SIGLES ET TERMES PEU USUELS

Ann.	=	Annexe
Dis.	=	Dessin
Ex.	=	Exemple
Fig.	=	Figure illustrante les pièces détachées
Max.	=	Maximum
Min.	=	Minimum
Mod.	=	Modèle de machine
N.	=	Numéro
N/A	=	Pas applicable (Not Applicable)
OFF	=	Machine arrêtée
ON	=	Machine en marche
OPP	=	Polypropylène orienté
PLC	=	Programmable Logic Control (Commandes à logique programmable)
PP	=	Polypropylène
PTFE	=	Polytétrafluoro-éthylène
PVC	=	Polyvinylchlorure
Ric.	=	Rappels
SIAT SpA	=	Società Internationale Applicazioni Tecniche (Société par actions)
Tav.	=	Table des matières

larg.	=	largeur
h	=	hauteur
long.	=	longueur
ol	=	longueur totale
cbh	=	hauteur plan de travail

1-AVANT-PROPOS

1.1 NORMES DE CONSTRUCTION

La banderoleuse semi-automatique mobile SR4-S a été projetée et construite pour répondre aux caractéristiques requises par la loi au moment de sa construction.
LES DOCUMENTS DE REFERENCE SONT LES SUIVANTS:
Directive CEE 98/37 concernant le rapprochement des législations des Etats membres relatives aux machines.
Directive 89/336/CEE concernant le rapprochement des législations des Etats membres relatives à la compatibilité électromagnétique.
Directive 73/23/CEE concernant le rapprochement des législations des Etats Membres relatives au matériel électrique destiné à être utilisé dans certaines limites de tension.
UNI EN 292-1 Sécurité des machines - Concepts fondamentaux, principes généraux d'ingénierie- Terminologie, méthodologie de base
UNI EN 292-2 Sécurité des machines - Concepts fondamentaux, principes généraux d'ingénierie- Spécifications et principes techniques
UNI EN 294 Sécurité des machines. Distances de sécurité pour empêcher aux membres supérieurs de s'approcher de zones dangereuses.
UNI EN 349 Sécurité des machines. Espaces minimums pour éviter l'écrasement de parties du corps.
UNI EN 418 Sécurité des machines. Dispositifs d'arrêt d'urgence, aspects fonctionnels. Principes d'ingénierie.
UNI EN 457 Sécurité des machines. Signaux acoustiques de danger - Caractéristiques générales, ingénierie et essais.
UNI EN 954 Sécurité des machines. Parties des systèmes de commande liées à la sécurité - Principes généraux d'ingénierie.
UNI EN 1050 Sécurité des machines. Principes d'évaluation du risque.
CEI EN 60204-1 Sécurité des machines. Equipements électriques de machines - Partie 1 : Règles générales.

1.2 COMMENT LIRE ET UTILISER LE PRESENT MANUEL D'INSTRUCTIONS

1.2.1 IMPORTANCE DU MANUEL

Le manuel fait partie intégrante de la machine. Les instructions qu'il contient vous aideront à maintenir votre machine en parfait état de marche et à travailler en toute sécurité.
Conserver donc ce manuel pour toute la durée de vie de la machine.S'assurer que toute modification transmise par le constructeur est régulièrement incorporée dans le texte. Transmettre le manuel à tout nouvel utilisateur et, le cas échéant, au nouveau propriétaire de la machine.Les schémas électriques et pneumatiques sont normalement annexés au manuel.Pour les machines les plus complexes, dotées de commandes à logique programmable ou de composants électroniques, les schémas peuvent figurer sur le tableau de commandes ou être fournis séparément.

1.2.2 CONSERVATION DU MANUEL

Conserver le manuel à l'abri de l'humidité et de la chaleur. Ne pas en supprimer, arracher ou réécrire certaines parties, pour quelque motif que ce soit. Prendre soin de ne pas l'abîmer en le consultant.
En cas de perte ou d'endommagement du manuel, demander un nouvel exemplaire au service après-vente, en spécifiant le numéro de code du document.

1.2.3 CONSULTATION DU MANUEL

Le manuel comprend:
- une présentation du document et de la machine:;
- un index analytique par thème:;
- des instructions et des indications sur la machine: chap. 2÷14;
- des annexes: croquis et schémas: chap. 15÷16;
- l'indication des pièces de rechange, à la fin du manuel.

Toutes les pages et tous les tableaux sont numérotés et les différentes pièces sont identifiées par le numéro de la figure qui les représente. Toutes les consignes de sécurité et les indications de dangers possibles sont signalés par le pictogramme:

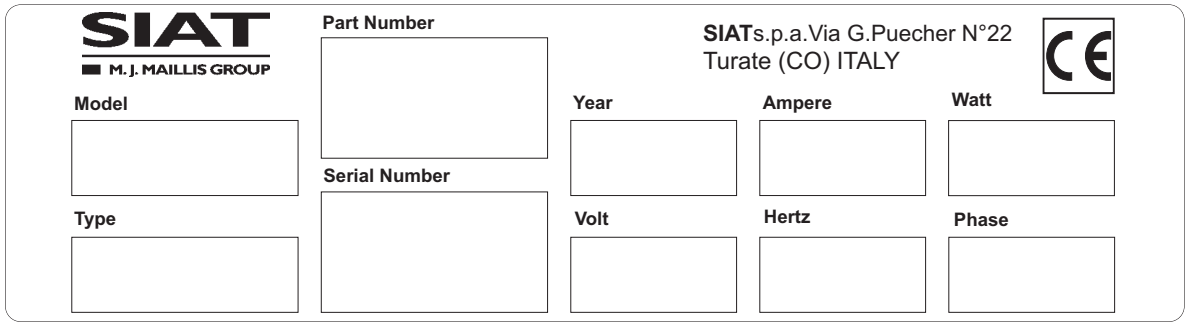
Les avertissements importants pour le fonctionnement de la machine sont précédés du signe: ☞
Les parties en caractères gras signalent les principaux points ou caractéristiques techniques abordés.

1.2.4 MISE A JOUR DU MANUEL EN CAS DE MODIFICATIONS APPORTEES A LA MACHINE

Des modifications de la machine sont susceptibles d'être introduites par le constructeur, suivant une procédure interne propre. Au moment où il reçoit la machine, l'utilisateur se voit remettre le manuel complet et mis à jour. Par la suite, il pourra recevoir des pages ou des parties de manuel contenant des modifications ou des améliorations apportées après sa publication. Celles-ci devront être intégrées dans le manuel.

2-INFORMATIONS GENERALES

2.1 NUMERO DE SERIE DE LA MACHINE ET NOM DU CONSTRUCTEUR



2.2 POUR L'ASSISTANCE TECHNIQUE ET LES PIECES DE RACHANGE, S'ADDRESSER A:

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2.3 GARANTIE

Le fournisseur s'engage, dans les limites indiquées ci-dessous, à assurer la réparation de tout défaut de construction susceptible d'apparaître au cours des six (6) mois qui suivent la mise en service de la machine et, quoi qu'il en soit, dans une période n'excédant pas huit (8) mois à compter de sa date d'expédition.
Sont expressément exclues de cette garantie les pièces soumises à une usure normale (comme les courroies, les galets/rouleaux en caoutchouc, les garnitures, les brosses etc.) ainsi que les pièces électriques.
Pour bénéficier de cette garantie, le client doit immédiatement signaler au fournisseur les défauts observés en précisant le numéro de série de la machine et faire parvenir au fournisseur la pièce défectueuse pour en permettre la réparation ou la substitution. Le fournisseur procèdera à la réparation ou substitution des pièces dans un délai raisonnable. Ce faisant il se sera pleinement acquitté des obligations qui lui échoient de par la présente garantie. Si la réparation ou le remplacement doivent être effectués sur le lieu d'installation de la machine, les frais de main-d'oeuvre, de déplacement et de séjour des techniciens ou des monteurs seront entièrement à la charge de l'acquéreur.

Le fournisseur n'est pas responsable des défauts occasionnés par:

- une mauvaise utilisation de celle-ci;
- le manque d'entretien de la machine;
- des manipulations ou réparations faites par l'acquéreur

Le fournisseur n'est en outre pas responsable des éventuels dommages occasionnés à des personnes ou des choses et décline toute responsabilité en cas de production non portée à terme.

Pour le matériel non construit par le fournisseur, comme les appareils électriques et les moteurs, celui-ci accorde à l'acquéreur la même garantie que celle qui lui est donnée par les fournisseurs de ces éléments.

Le constructeur ne garantit pas la conformité des machines avec les dispositions législatives en vigueur dans les pays non membres de l'Union européenne, tout particulièrement pour ce qui concerne la prévention des accidents et la pollution.

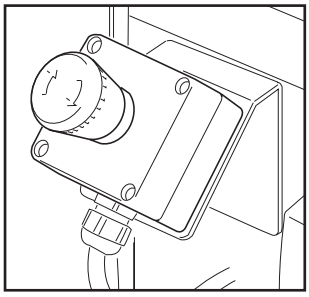
L'adaptation des machines aux dispositions en question est à charge de l'acquéreur qui assume toutes les responsabilités en la matière et exclut toute responsabilité du fournisseur en cas de réclamation de tiers pour les éventuelles conséquences du non respect de ces normes.

3-SECURITE

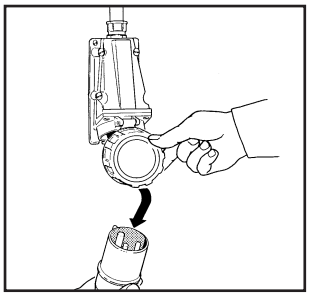
3.1 CONSIGNES GENERALES DE SECURITE

Lire attentivement toutes les instructions avant de commencer à utiliser la machine. Prêter une attention toute particulière aux sections précédées du pictogramme

La machine enrubanneuse Mod. SR46-S est dotée d'un bouton d'ARRET D'URGENCE verrouillable, placé à coté de l'operateur; dès que l'on appuie sur le bouton, la machine s'arrête en n'importe quelle phase du cycle de fonctionnement.



Débrancher la prise de courant avant d'entreprendre toute opération d'entretien.



Conserver précieusement ce manuel d'instructions: les informations qu'il contient vous aideront à maintenir la machine en parfait état de marche et de fonctionnement en toute sécurité.

3.2. DEFINITIONS DES FUNCTIONS DES OPERATEURS

- Opérateur chargé de la conduite de la machine;
- Technicien chargé de l'entretien;
- Technicien chargé de l'entretien électrique;
- Technicien du constructeur

Le travail avec la machine peut être effectué seulement par une personne qualifiée pour le fonctionnement.
Il est la responsabilité de l'utilisateur de définir la personne qualifiée, les différents niveaux d'intervention et donner à chacun les consignes de travail comme elles sont définies dans ce manuel.

NIVEAU 1

OPERATEUR CHARGE DE LA CONDUITE DE LA MACHINE
Cet opérateur est habilité, après une formation spécifique, à assurer le fonctionnement de la machine et, plus précisément, à actionner l'interrupteur général et le bouton d'arrêt d'urgence, à introduire les boîtes, à procéder aux différents réglages selon les dimensions des boîtes, à changer le ruban et à faire démarrer, arrêter et remettre en marche la machine.
N.B. Les responsables de l'établissement doivent s'assurer que l'opérateur a reçu la formation nécessaire pour effectuer toutes les opérations, avant de lui confier la machine.

NIVEAU 2

TECHNICIEN CHARGE DE L'ENTRETIEN
Technicien qualifié en mesure d'accomplir les tâches de l'opérateur et, en outre, de faire fonctionner la machine avec les protections désactivées, d'intervenir sur les parties mécaniques pour les opérations de réglage, d'entretien et de réparation nécessaires.
Par contre, il n'est pas habilité à intervenir sur des installations électriques sous tension.

NIVEAU 2a

ELECTRICIEN CHARGE DE L'ENTRETIEN ELECTRIQUE
Technicien en mesure d'accomplir les tâches de l'opérateur de la machine et, en outre, de la faire fonctionner avec les protections débranchées, d'intervenir sur les réglages et sur les circuits électriques pour les opérations d'entretien et de réparation.
Il est habilité à travailler en présence de tension sur les panneaux électriques, les boîtes de dérivation, les équipements de commande etc.

NIVEAU 3

TECHNICIEN DU CONSTRUCTEUR
Technicien qualifié du constructeur ou de son représentant, intervenant pour les opérations plus complexes, à la demande de l'utilisateur.

3.3 RECOMMANDATIONS POUR INTERVENIR EN TOUTE SECURITE SUR LA MACHINE

Les opérateurs doivent nécessairement posséder les qualifications spécifiées ci-dessous et au 3.6.
Il appartient à l'utilisateur de désigner les opérateurs qualifiés pour les différentes tâches et de leur fournir la formation appropriée ainsi que de leur transmettre les instructions contenues dans ce manuel.

3.4 MODES DE FONCTIONNEMENT

Liste des différents modes opératoires de la machine:
- fonctionnement automatique;
- fonctionnement avec protections débranchées;
- arrêt à l'aide de l'interrupteur général;
- arrêt à l'aide du bouton d'arrêt d'urgence verrouillable;
- alimentation électrique déconnectée.
- raccord air comprimé déconnecté.

3.5 NOMBRE D'OPERATEURS

Les opérations décrites ci-dessous ont été analysées par le constructeur; on trouvera indiqué le nombre d'opérateur nécessaire pour le déroulement optimal de chacune d'entre elles. Un nombre d'opérateurs inférieur ou supérieur pourrait mettre en danger la sécurité du personnel employé.

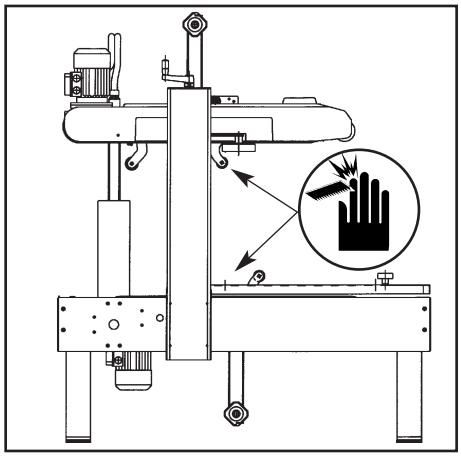
3.6 QUALIFICATION DES OPERATEURS

Qualification minimum requis pour chaque operation.

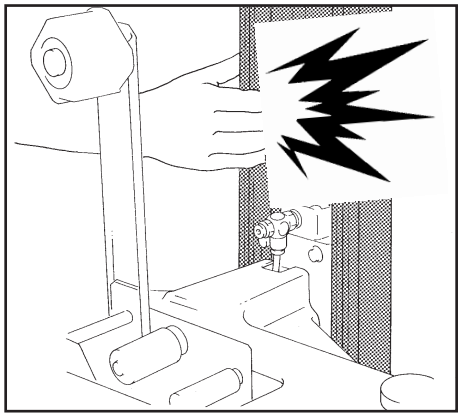
OPERATION	MODE DE FONCTIONNEMENT	NIVEAU DE QUALIFICATION	NOMBRE OPERATEURS
Installation et operations preliminaires.	Marche avec protections débranchées.	**2 e 2a**	2
Réglage des dimensions des boîtes.	Arret avec bouton D'ARRET D'URGENCE verrouillable.	**1**	1
Remplacement du ruban.	Arret avec bouton D'ARRET D'URGENCE verrouillable.	**1**	1
Remplacement des lames.	Branchement électrique et pneumatique déconnectés.	**2**	1
Remplacement des courroies d'entraînement.	Branchement électrique et pneumatique déconnectés.	**2**	1
Entretien mecanique ordinaire.	Branchement électrique et pneumatique déconnectés.	**2**	1
Entretien electrique ordinaire.	Branchement électrique et pneumatique déconnectés.	**2a**	1
Entretien mecanique extraordinaire.	Marche avec protections desactivées.	**3**	1
Entretien electrique extraordinaire.	Marche avec protections desactivées .	**3**	1

3.7 RISQUES RESIDUELS

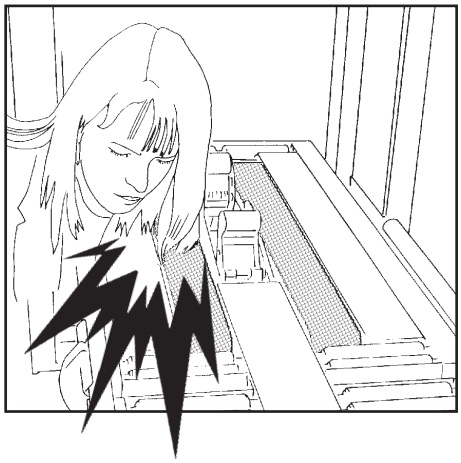
La machine SR46-S a été produite en conformité avec la norme CE 392 avec plusieurs dispositifs de protection qui ne doivent pas être modifiés ou désactivés.
Nonobstant les précautions pour la sécurité, il est essentiel que l'opérateur et les techniciens affectés à la manutention soient prévenus de façon préventive des dangers induits qui ne sont pas tous éliminés:



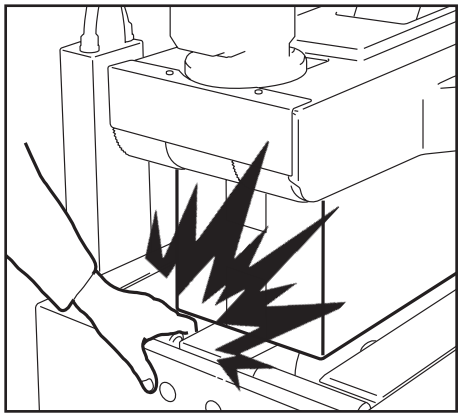
ATTENTION! Lame de coupe du ruban.
Ne jamais enlever le dispositif de sécurité qui protège la lame de coupe des unités d'enrubannage inférieure et supérieure.
Les lames étant extrêmement coupantes, toute erreur pourrait provoquer de graves blessur



ATTENTION! Colonnes pneumatiques de décharge.
Ne pas approcher les mains aux colonnes, danger d'écraseme

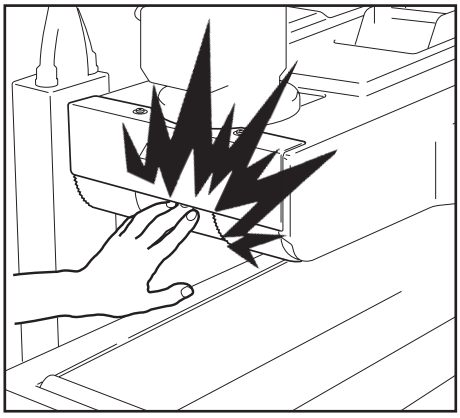


ATTENTION! Courroies latérales d'entraînement supérieures et inférieures.
Ne jamais s'approcher de la machine avec les cheveux libres, un foulard ou une cravate non retenus, des manches larges etc. Bien qu'elles soient protégées par des carters, les courroies d'entraînement peuvent être dangereuses.



ATTENTION! Cavités sur le plan de glissement à la sortie des boîtes.
Ne jamais enfiler les mains à l'intérieur de la machine pendant qu'elle est en mouvement. Danger d'écrasement.

ATTENTION! Courroies d'entraînement supérieures.
Ne toucher jamais la courroie d'entrainement en mouvement avec les mains.
Danger d'écrasement.



3.8 RECOMMANDATIONS POUR EVITER LES DANGERS QUI NE PEUVENT ETRE ELIMINES

Le poste de travail de l'opérateur est à la place indiquée à le paragraph. 12.1. Il est invité à ne pas s'en écarter. Il ne doit jamais toucher les courroies en mouvement ou les parties internes de la machine en marche et éviter de mettre ses mains dans les cavités. Il doit veiller à introduire la boîte en maintenant les mains dans la position correcte (voir paragraph. 4.9). Il lui faut, en outre, faire très attention aux lames au moment du changement des rubans.

3.9 MOYENS DE PROTECTION PERSONNELS

Aucun moyen de protection personnelle (lunettes, gants, casque, chaussures, masque respiratoire, bouchons d'oreilles) est recommandé, à moins qu'il ne soit prescrit par l'utilisateur.

3.10 PRECAUTIONS A PRENDRE ET GESTES A EVITER

- Ne jamais essayer d'entraver l'action d'entraînement de la boîte sans avoir préalablement appuyé sur le bouton d'ARRET D'URGENCE.

- Ne jamais utiliser la machine avec les protections démontées.

- Ne pas désactiver les dispositifs de sécurité.

- Seul le personnel habilité pourra effectuer les opérations de réglage, de réparation et d'entretien requérant la mise en marche de la machine avec les protections débranchées.
  Pendant ces opérations, l'accès à la machine ne sera autorisé qu'aux opérateurs dûment qualifiés.
  A la fin de chaque intervention, les dispositifs de protection seront immédiatement réactivés.

- Les opérations d'entretien et de nettoyage ne doivent être effectuées qu'après avoir coupé le courant.

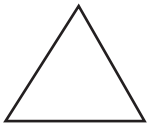
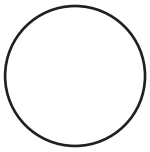
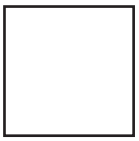
- Nettoyer la machine uniquement à l'aide de chiffons secs ou de détergents légers.
  Ne pas utiliser de solvants, d'essences ou d'autres produits analogues.

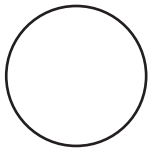
- Ne pas modifier la machine ou certaines de ses pièces.
  Le constructeur décline toute responsabilité quant aux conséquences de telles interventions.

- Pour toute modification éventuelle, il est conseillé de s'adresser au constructeur Siat S.p.A.

- Installer la machine suivant les procédures ou les schémas indiqués
  Le constructeur décline toute responsablité en cas d'installation non conforme aux instructions.

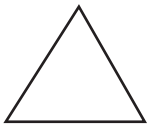
3.11 TABLEAU RECAPITULATIF DES PRINCIPAUX SIGNAUX, ETIQUETTES, PLAQUES ET PICTOGRAMMES APPOSES SUR LA MACHINE

	LÉGENDE DES SYMBOLES	LÉGENDES COULEURS
	DANGER ET PARTIES DE LA MACHINE EN MOUVEMENT	COULEUR JAUNE
	OBLIGATION / INTERDICTION	COULEUR ROUGE
	COMMANDES ET INFORMATIONS	COULEUR BLEU

a 

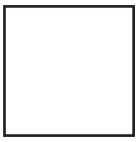
Indique que la butée de fin de course utilisée pour le réglage de la hauteur de la tête supérieure ne doit pas être débloquée en absence de pression d'air.

Code ètiquette: 3.0.010604.96/A

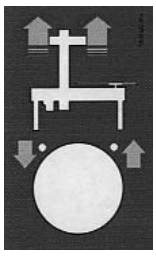
b 

Informe l'opérateur de ne pas toucher le levier qui contrôle le soulèvement de la tête supérieure.

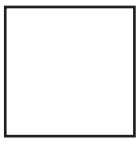
Code etiquette: 3.0.01029.96A

c 

Indique le sélecteur soulèvement / abaissement de la tête supérieure, qui facilite l'extraction de l'unité enrubaneuse inférieure.

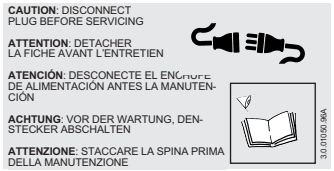


Code etiquette: 3.0.01047.96A

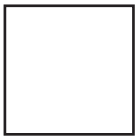
d 

Indique qu'il est obligatoire de débrancher la fiche de la prise d'alimentation avant de commencer toute opération d'entretien.

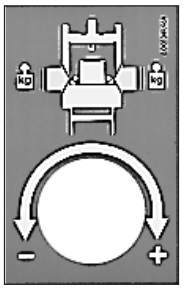
.


CAUTION: DISCONNECT PLUG BEFORE SERVICING
ATTENTION: DETACHER LA FICHE AVANT L'ENTRETIEN
ATENCIÓN: DESCONECTE EL ENCHUFE DE ALIMENTACIÓN ANTES LA MANUTENCIÓN
ACHTUNG: VOR DER WARTUNG, DEN-STECKER ABSCHALTEN
ATTENZIONE: STACCARE LA SPINA PRIMA DELLA MANUTENZIONE
3.0.01050.96A

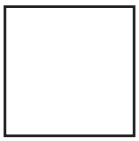
Code ètiquette: 3.0.01050.96A

e 

Indique le bouton pour le réglage de la pression des guides latéraux.

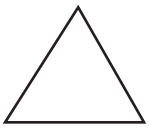


Code ètiquette: 3.0.01049.96A

f 

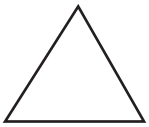
Indique le bouton pour le réglage du poids de la tête sur la boîte.

Code ètiquette: 3.0.01048.96A

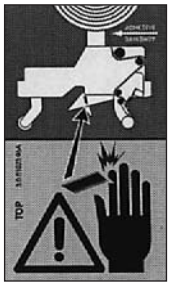
g 

Indique le danger de la lame tranchante de l'unité enrubaneuse.

Code ètiquette: 3.0.01028.96A

h 

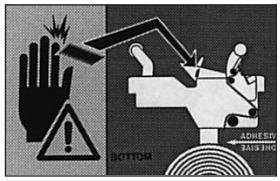
Indique le parcours du ruban de l'unité enrubaneuse supérieure et le danger de la lame tranchante.



Code ètiquette: 3.0.01023.96A

i

Indique le parcours du ruban de l'unité enrubaneuse inférieure et le danger de la lame tranchante.



Code ètiquette: 3.0.01024.96A

l

Indique le sens de marche des courroies d'entraînement.

Code ètiquette: 3.0.01040.96A

m

Indique la présence d'air dans le circuit (voyant rouge visible).

Code ètiquette: 3.0.01035.96A

n

Informe l'opérateur de ne pas toucher le levier qui contrôle la fermeture/ouverture des guides latéraux.

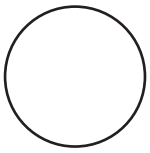
Code etiquette: 3.0.01027.96A

o

Informe l'opérateur de pas introduire les mains où des objets dans les cavites des guides latéraux.

Code ètiquette: 3.0.01036.96A

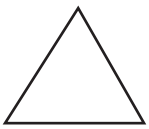
p



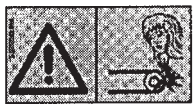
Avertit l'utilisateur de ne pas toucher les colonnes, à l'intérieur desquelles se trouve le cylindre de soulèvement de la tête supérieure.

Code ètiquette: 3.0.01041.96A

q

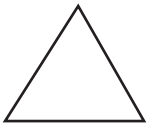


Indique le danger des courroies d'entraînement supérieures en mouvement.



Code ètiquette: 3.0.01030.96A

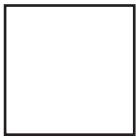
r



Indique le danger des courroies d'entraînement inférieures en mouvement..

Code ètiquette: 3.0.01031.96A

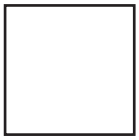
s



Indique les commandes de marche/arrêt et met en évidence la présence de courant électrique à l'intérieur de la boîte de l'interrupteur magnétothermique.

Code ètiquette: 3.0.01090.96A

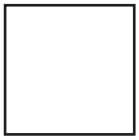
t



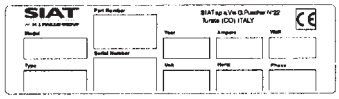
Indique le point de raccord du fil de protection avec le corps de la machine (mise à la terre).

Code ètiquette: 3.0.01039.96A

u



Reporte les données d'identification du modèle, numéro de matricule et de fabrication de la machine.



Code ètiquette: SBC0000629

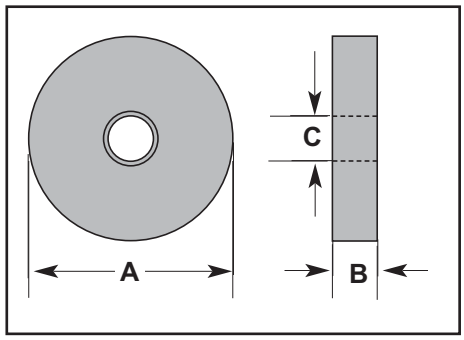
4-INFORMATIONS PRELIMINAIRES SUR LA MACHINE

4.1 DESCRIPTION GENERALE DE SR46-S

Machine enrubanneuse automatique à courroies d'entraînement supérieures et inférieures et réglage manuel, pour la fermeture de boîtes.

4.2 DONNEES TECHNIQUES

- Production moyenne = 650 boîtes/heure
- Alimentation standard = 230/400V 50Hz 3Ph
- 2 moteurs (HP 0,18) kW 0,12
- Unités enrubannage K12, largeur du ruban 75 mm
- Poids = 165 kg
- Vitesse des courroies = 22 m/minute
- Air comprimé max 6 bar.



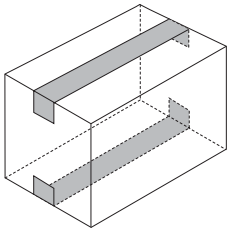
A = 410 mm max
B = 75 mm
C = 76 mm

4.3 DIMENSIONS DU RUBAN

Suitable adhesive tapes:
Rubans adhésifs appropriés:
PVC
OPP
PAPIER ADHÉSIF

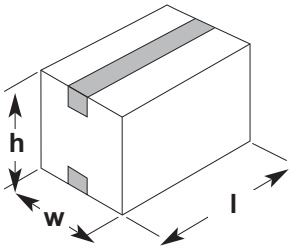
4.4 USAGE PREVU

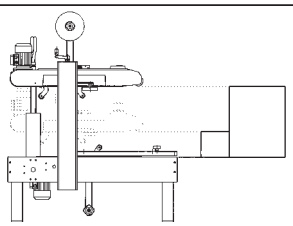
Fermeture, à l'aide de ruban adhésif, de boîtes des dimensions indiquée (en millimètres) dans l'encadré 4.5au moyen de l'applicationsimultanée de deux bandes de ruban adhésif (l'une sur la partie supérieure de la boîte, l'autre sur la partie inférieure). Le modèle doté d'un système électrique standard n'est pas adapté à un emploi en milieu explosif où sont nécessaires des composants anti-déflagrants et/ou des moteurs à air.



4.5 GAMME DE DIMENSIONS BOITES

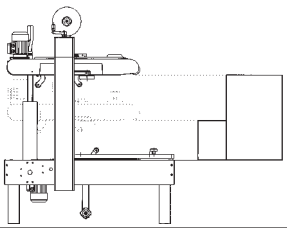
La machine SR46-S est réglable manuellement pour la fermeture des cartons selon les dimensions indiquées dans la partie n° 1.
Pour la fermeture de cartons avec une haeuture supèrieure à 750 mm, il est possiblede déplacer la position des colonnes fixes, comme indiqué dans le schémasuivant (partie 2).





1 COLONNES FIXEES EN POSITION

MEASURES CARTONS		MIN	MAX
	L	**150**	
	W	**170**	**650**
	H	**130**	**750**



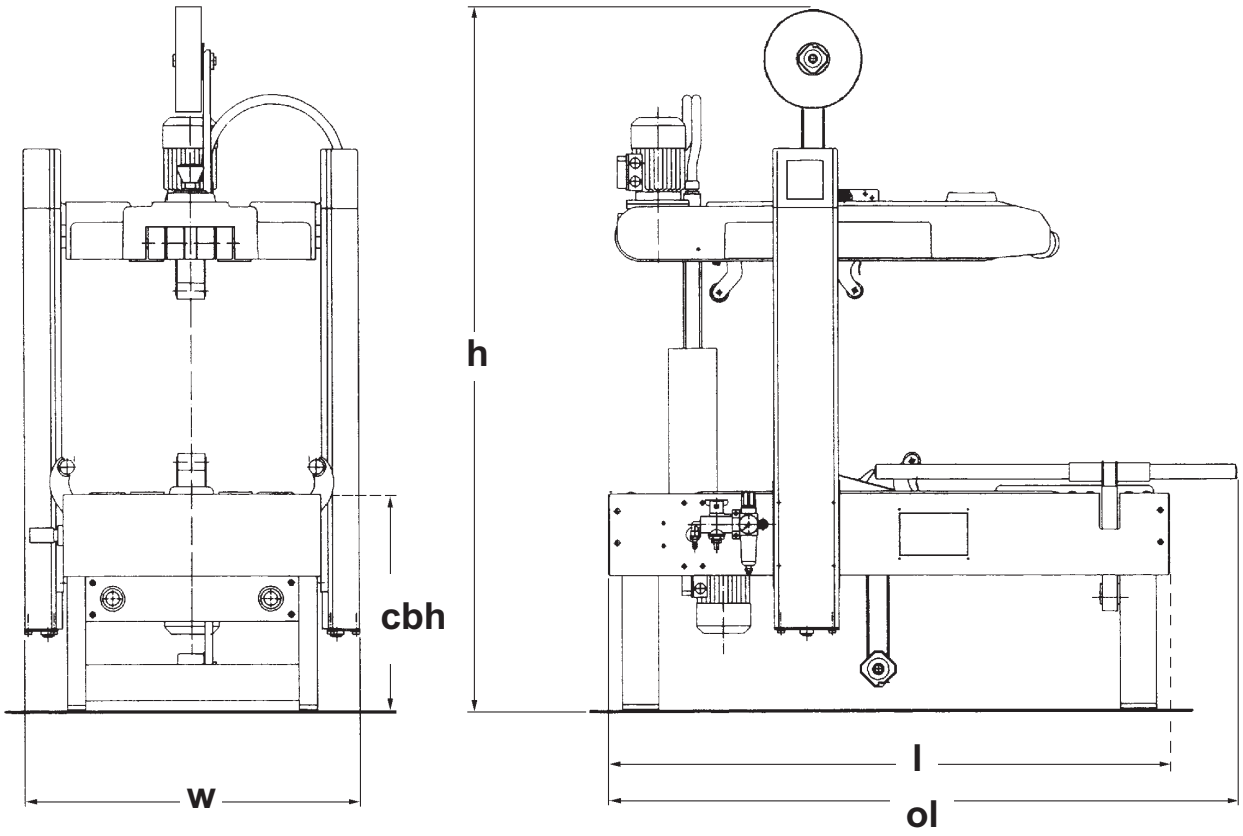
2 COLONNES FIXEES EN POSITION HAUTE

MEASURES CARTONS		MIN	MAX
	L	**150**	
	W	**170**	**650**
	H	**340**	**930**

NOTE

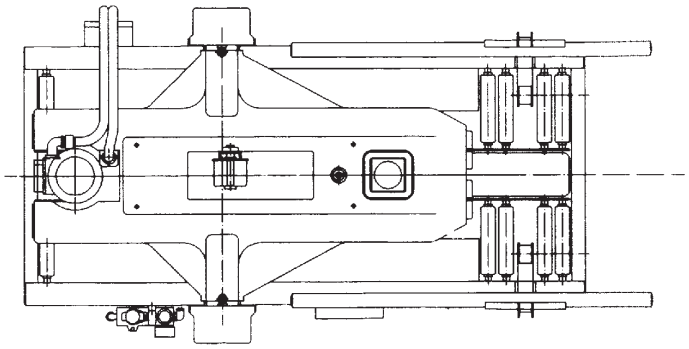
- La longueur des caisses (L) se réfère à la longueur dans le sens de la fermeture.
- Les cartons doivent avoir un rapport L/H (LONGUEUR/HAUTEUR) supérieures à 0,5. Pour des cartons ayant un rapport inférieur, il faut effectuer un test pour être certain du fonctionnement final, qui dépend des différents facteurs ayant trait au poids et à la solidité du carton.
- En aucun cas le fabricant peut apporter des modifications spéciales à la machine SR46-S pour faire passer des cartons plus petits ou plus grands que ceux
indiqués. Dans ce cas, contactez le service d'assistance technique de Siat Spa.

4.6 DIMENSIONS COMPLETES



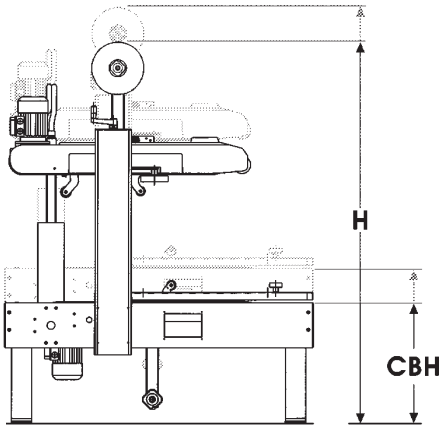
DIMENSIONS DE LA MACHINE

l = longueur 1240 mm
w = largeur 740 mm
h = hauteur 1275÷2025 mm
ol = longueur hors - tout, incluant les barres-centreur : 1390mm
cbh = hauteur du plan de travail : paragraph 4.7



4.7 HAUTEUR PLAN A ROULEAUX

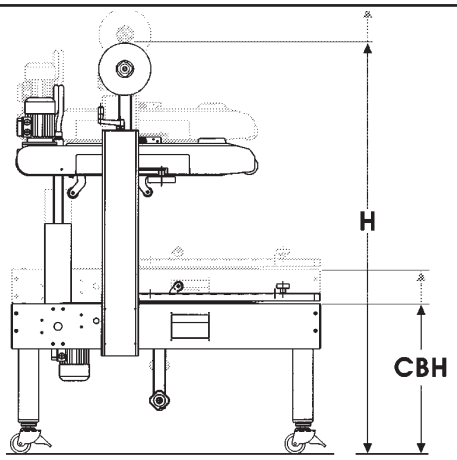
La machine SR46-S intègre une marge de réglages et de régulation de la hauteur du plan de travail des cartons. Plusieurs combinaisons sont possibles qui peuvent être obtenues avec des accessoires en option AS77 (roulettes) ou AS80 (pieds): se réfèrer à la table des matières à la page suivante.



A AVEC PIEDS STANDARD

HAUTEUR PLAN TRAVAIL	MIN	MAX
CBH	**485**	**825**

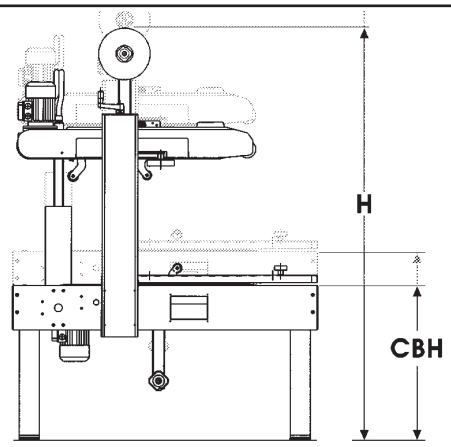
DIMENSIONS TOTALES	MIN	MAX
H	**1275**	**2025**
L	**1240**	**1240**
W	**940**	**940**



B AVEC ROULETTES AS77 (OPTIONS)

HAUTEUR PLAN TRAVAIL	MIN	MAX
CBH	**585**	**925**

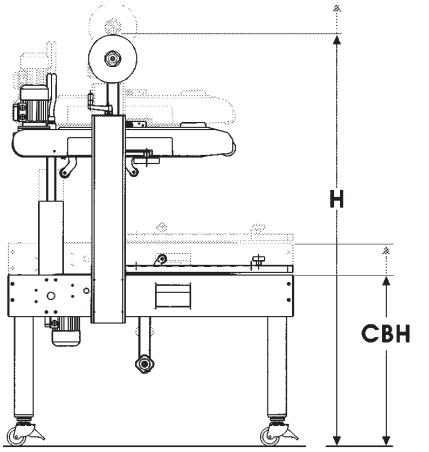
DIMENSIONS TOTALES	MIN	MAX
H	**1375**	**2125**
L	**1240**	**1240**
W	**940**	**940**



C AVEC PIEDS (OPTIONS)

HAUTEUR PLAN TRAVAIL	MIN	MAX
CBH	**645**	**1135**

DIMENSIONS TOTALES	MIN	MAX
H	**1435**	**2335**
L	**1240**	**1240**
W	**940**	**940**



D AVEC PIEDS AS80 ET ROULETTES AS77(OPTIONS)

HAUTEUR PLAN TRAVAIL	MIN	MAX
CBH	**745**	**1235**

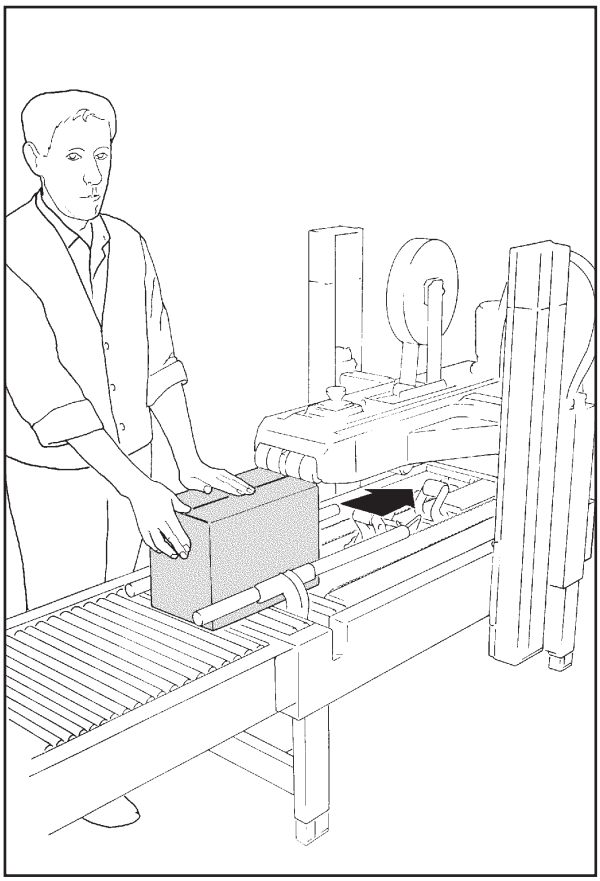
DIMENSION TOTALES	MIN	MAX
H	**1535**	**2435**
L	**1240**	**1240**
W	**940**	**940**

1.8 PRINCIPAUX COMPOSANTS

La machine est constituée de:
N. 1 chassis
N. 4 pieds réglables
N. 2 colonnes
N. 2 unités enrubanneuses
N. 1 tête supérieure
N. 1 motorisation supérieure
N. 1 motorisation inférieure
N. 2 moteurs électriques
N. 1 bouton d'arrêt d'urgence
N. 1 interrupteur principal ON/OFF
Pour les caractéristiques techniques des composants électriques voir section 15- ANNEXES

4.9 DEROULEMENT DE L'OPERATION

Une fois la boîte est remplie, fermer lesrabats supérieures et la pousser contrele levier qui contrôle la montée de la tête supérieure. Introduire la boîte dans la machine sur les courroies d'entraînement; la boîte serait entraînée par les courroies quand la tête supérieure serait descendue sur la boîte même.
Garder toujours les mains dans la position indiquée Tav.



La boîte est automatiquement fermée avec le ruban adhésif sur la partie supérieure et inférieure avant d'êtreévacuée sur le convoyeur de sortie.

4.10 MEASURE DU NIVEAU SONORE

Pression acoustique relevée à une distance de 1 m de la machine avec ruban adhésif inséré: 73 dB. Pression acoustique à une hauteur de 1,6 m de la machine avec un ruban adhésif inséré: 73 dB. Relevés effectués avec un instrument type SPYRI-MICROPHON.

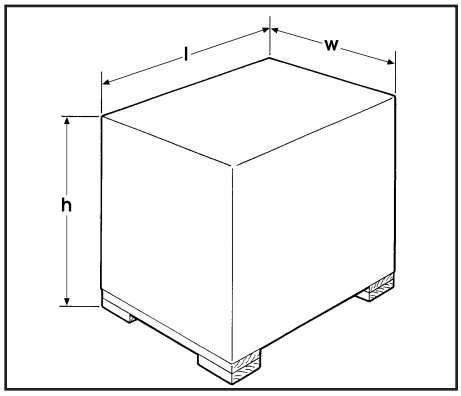
5-RANSPORT-MANUTENTION-ENTREPOSAGE

5.1 TRANSPORT ET MANUTENTION DE LA MACHINE EMBALLEE

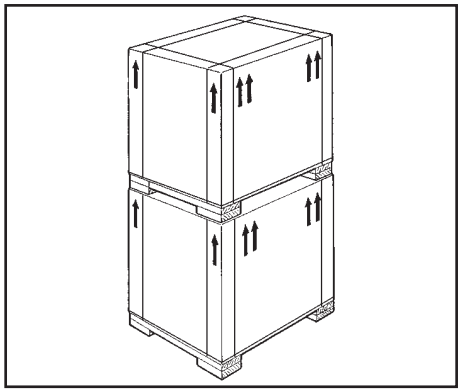
La machine est fixée à la palette par 4 étriers à boulons et peut être soulevée avec un chariot à fourches normales. L'emballage standard est étudié pour les transports par voie de terre ou par avion. Emballage pour transport maritime disponible sur demande.

DIMENSION DE L'EMBALLAGE

l = longueur 1400 mm
w = largeur 1000 mm
h = hauteur 1300 mm
Poids kg. 210

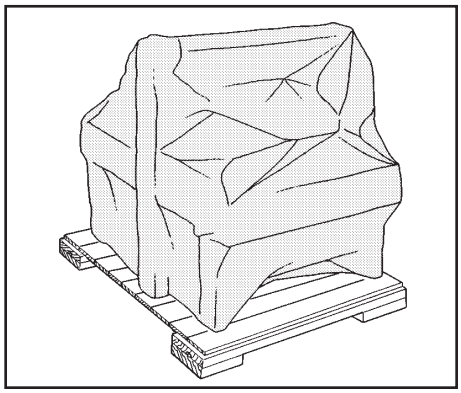


Au cours du transport, il est possible de superposer au maximum deux machines.



5.2 EMBALLAGE POUR TRANSPORT MARITIME (SUR DEMANDE)

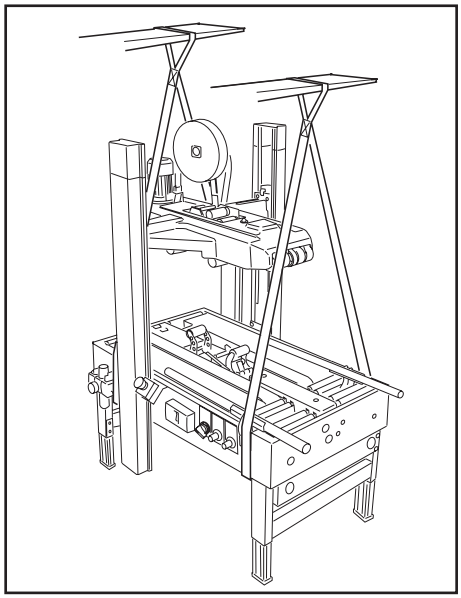
Les machines expédiées par mer sont enveloppées dans un sac multicouche en aluminium/polyester/polyéthylène contenant des sels hygroscopiques.



5.3 TRANSPORT ET MANUTENTION DE LA MACHINE EMBALLEE

La machine déballée peut être transporté pour des petites distances. Il transport de la machine déballée peut causer des dommages. Pour la deplacer, soulever-la avec des courroies comme indiqué et la soulever avec un chariot élévateur ou avec une grue.

DIMENSIONS DE LA MACHINE
longueur 1240 mm
largeur 940 mm
hauteur min.1275; max. 2025 mm
Poids kg 165

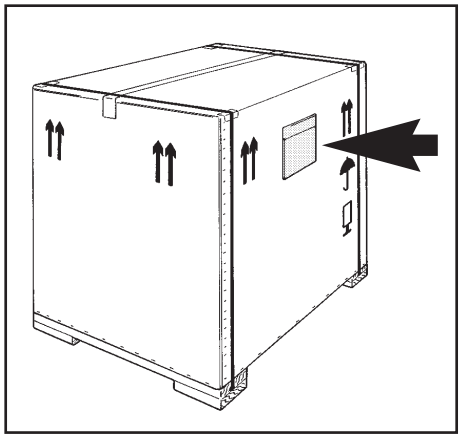


5.4 ENTREPOSAGE DE LA MACHINE EMBALLEE ET DEBALLEE

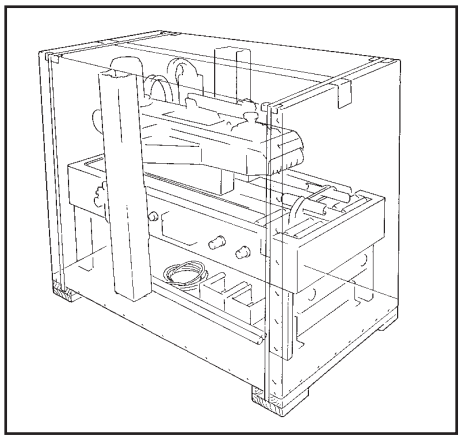
Précautions à prendre pour une longue période d'inactivité de la machine:
-l'entreposer dans un lieu sec et propre;
-si la machine est déballée, il est recommandé de la protéger contre la poussière et de ne rien poser dessus;
-Il est possible de superposer au maximum 2 machines si elles sont emballées.

6-DEBALLAGE

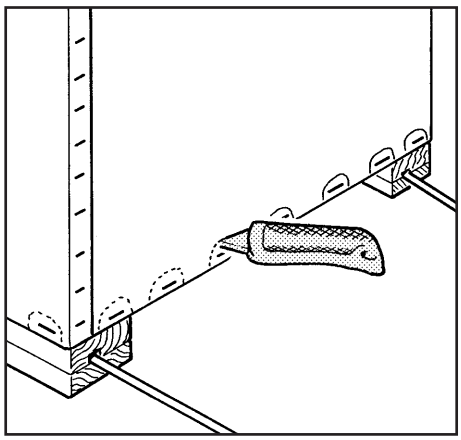
6.1 L'enveloppe collée à l'extérieur de l'emballage contient les instructions pour le déballage de la machine.



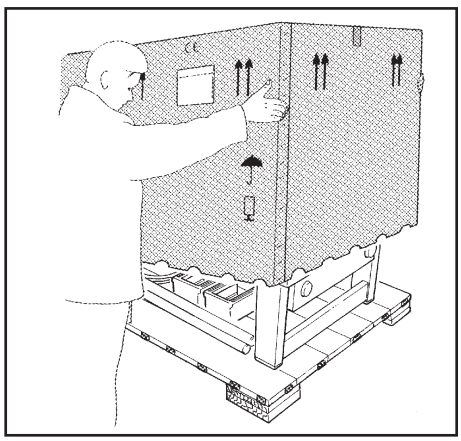
Position de la machine à l'intérieur de l'emballage.



Couper les feuillards en polypropylène.
Couper à l'aide d'un cutter la partie du carton fixée par les agrafes tout au long du bord de la caisse. (ou bien ôter les agrafes à l'aide de l'outil destiné à cet effet).

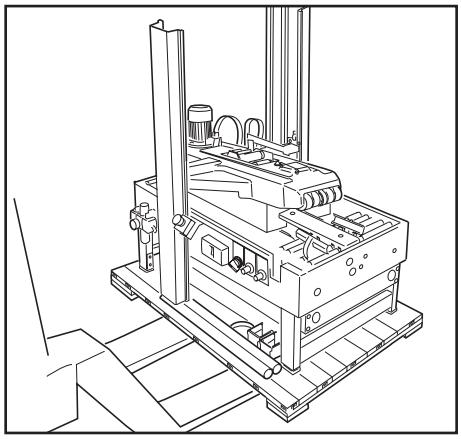


Après avoir coupé le bord inférieur ou enlevé les agrafes, soulever complètement le carton pour dégager la machine. (2 personnes).

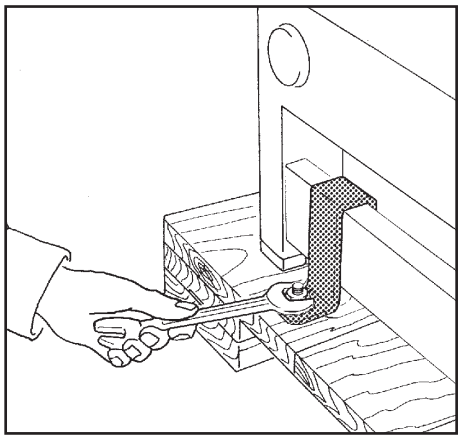


6-DEBALLAGE

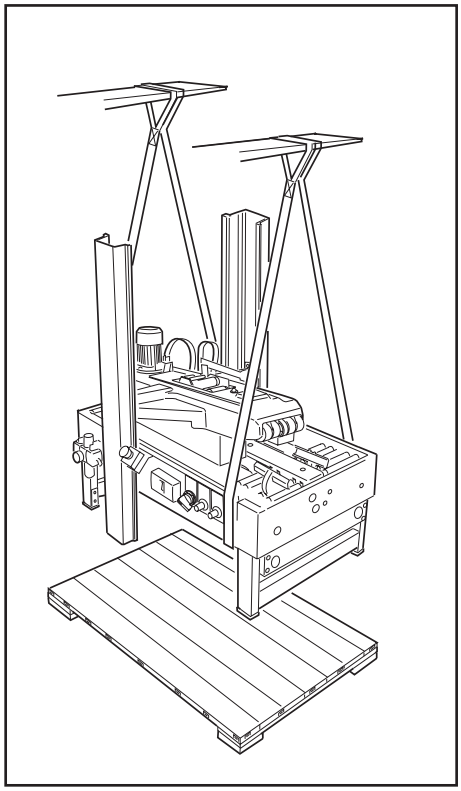
Transporter la machine à l'aide d'un chariot élévateur à fourche ou d'un transpalette jusqu'au point où elle devra être installée. (Poids machine + palette = 185 kg).



Desserrer les écrous et démonter, à l'aide des clés fournies avec la machine, les pattes qui la maintiennent fixée à la palette.



Soulever la machine selon la figure (poids de la machine 165 kg) et enlever la palette en bois.



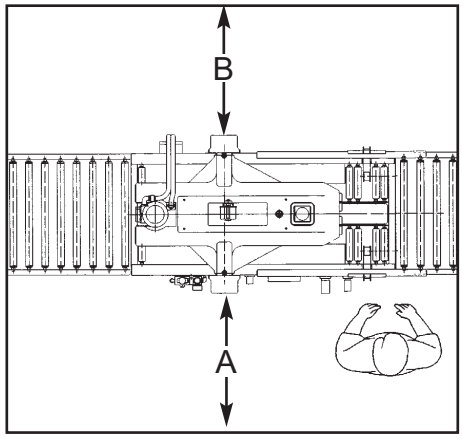
6.2 ELIMINATION DE L'EMBALLAGE

L'emballage de la machine SR46-S comprend:
- une palette en bois;
- une caisse en carton;
- des étriers de fixation en acier;
- une protection en mousse de polyéthylène;
- des feuillards en plastique (PP)
- des sels hygroscopiques sous forme d'argile
- un sac en aluminium/polyester/polyéthylène (uniquement pour le transport maritime).

Pour l'élimination de ces matériaux, l'utilisateur se conformera aux dispositions législatives en vigueur dans son pays.

7-INSTALLATION

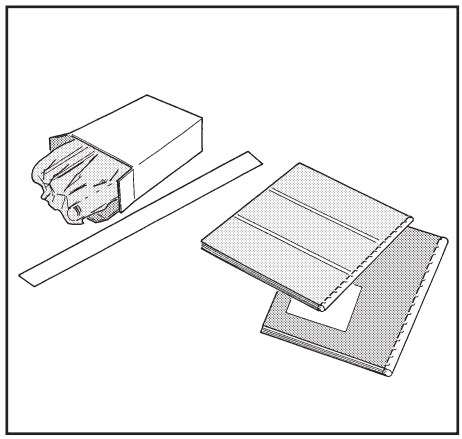
7.0 SÉCURITÉ
(Voir chapitr 3).



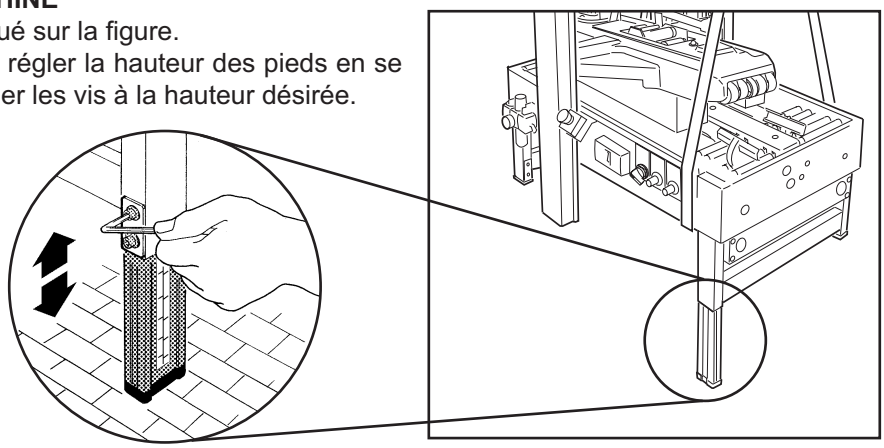
7.1 CONDITIONS AMBIANTES
- Température min. = 5 °C; Température max. = 40 °C
- Humidité min. 30%; Humidité max. 80%
- Environnement dénué de poussière

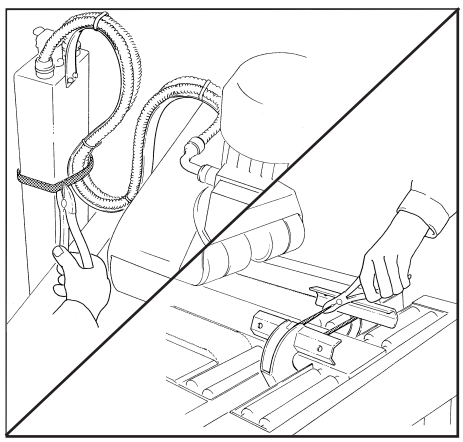
7.2 ESPACE NECESSAIRE POUR LE FONCTIONNEMENT ET L'ENTRETIEN
Distance minimale du mur
A = **1000** mm
B = **700** mm; Hauteur sous plafond minimale = **2500** mm

7.3 PIECES DETACHEES ET TIRE-TUBAN POUR LES UNITES ENRUBANEUSES
Voir chapitr 13.1.



7.4 MISE EN POSITION DE LA MACHINE
Soulever la machine comme indiqué sur la figure.
Débloquer les vis en illustration et régler la hauteur des pieds en se référant à l'échelle graduée. Bloquer les vis à la hauteur désirée.

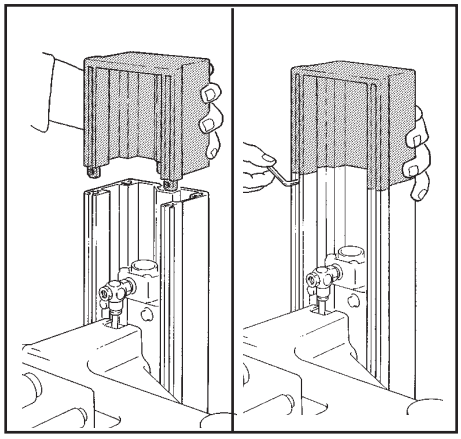




7.5 DEBLOQUAGE DE LA MACHINE
Couper le collier, qui bloque la bande et les gaines avec les câbles de l'alimentation moteur et du bouton d'arrêt d'urgence, ainsi que le collier qui bloque les leviers du centreur.

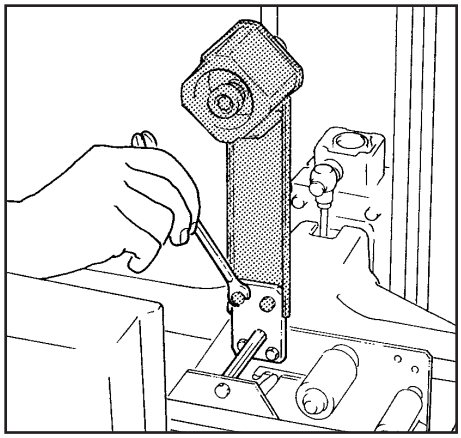
7.6 PLACEMENT PROTECTIONS COLONNES

Récupérer les colonnes de protection et les monter comme indiqué sur la figure.



7.7 PLACEMENT DU PORTE-ROULEAU SUPERIEUR

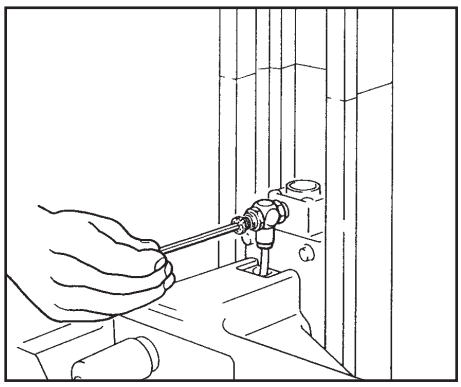
Débloquer les vis qui fixent le porte-rouleau sur la machine, le positionner selon la figure et le bloquer avec les vis enlevées précédemment.

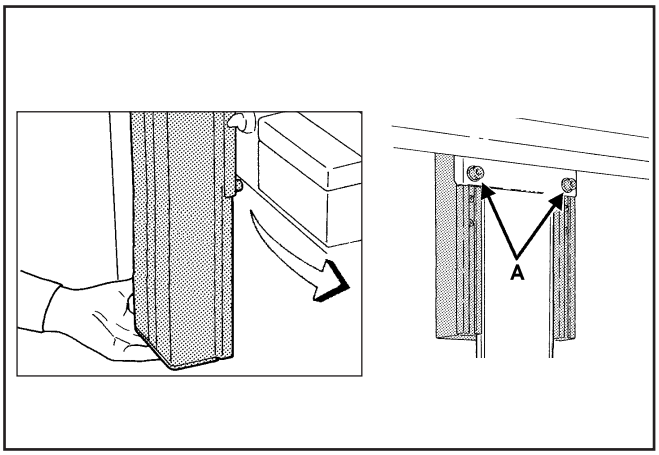


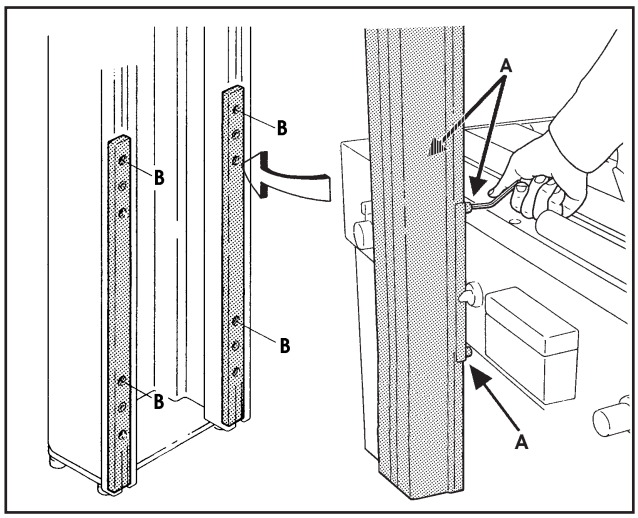
7.8 PLACEMENT DES COLONNES

Dévisser le bouchon du cylindre pneumatique.

Tenir avec une main la colonne et débloquer les deux vis A. Pousser la colonne vers le haut jusqu'à ce qu'elle soit à la hauteur des trous B.
Récupérer les deux autres vis jointes avec les pièces de rechange et fixer la colonne (quatre vis par colonne)

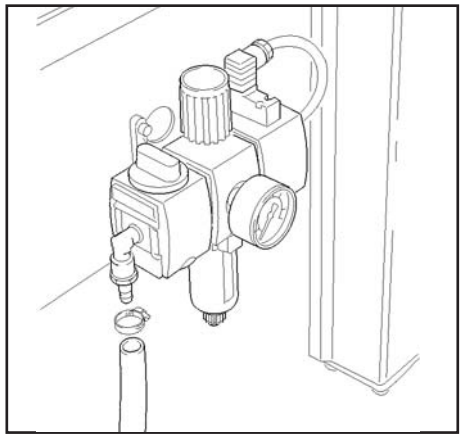




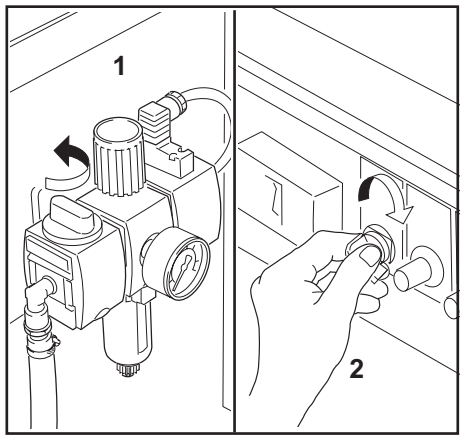


7.9 BRANCHEMENT PNEUMATIQUE

Relier un tube de 8 mm au raccord et le fixer avec le collier joint.

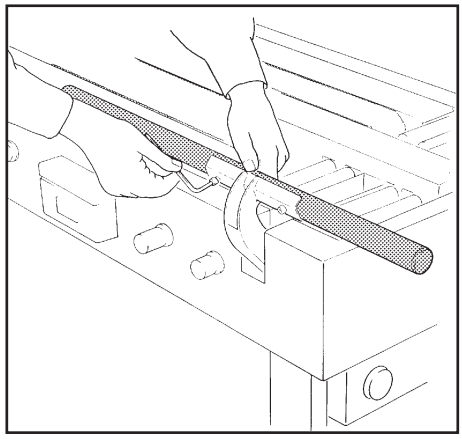


Activer le circuit pneumatique en utilisant la manivelle **1** et soulever la tête supérieure à l'aide du sélecteur **2**.
Retirer les blocs de polystyrène utilisés pour le transport.



7.10 PLACEMENT DES GUIDES LATERALES

Monter les guides de la boîte sur les leviers du centreur comme illustré sur la figure.



7.11 CONTROLES ELECTRIQUES PRELIMINAIRES

Avant de brancher la machine à la prise de courant, effectuer les contrôles suivants:

7.11.1 S'assurer que la prise est munie du circuit de protection et que le voltage et la fréquence d'alimentation correspondent à ceux indiquées sur la plaquette de la machine.

7.11.2 Il appartient à l'utilisateur de s'assurer que le branchement de la machine au réseau est conforme aux normes en vigueur dans le pays de l'installation.

7.11.3 La machine est équipée d'un interrupteur général avec pouvoir d'interruption de 6 kA et d'un sectionneur qui intervient à 120 A.Il appartient à l'utilisateur de contrôler le courant de court-circuit de son installation et de vérifier que l'intensité de courant prévue aux bornes de l'interrupteur général est compatible avec la machine.

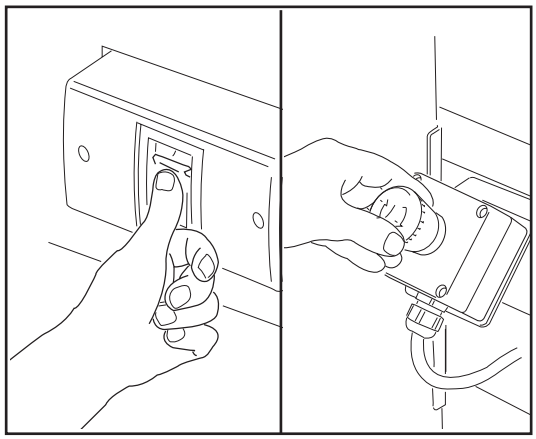
7.12 BRANCHEMENT ELECTRIQUE ET CONTROLES

Puissance installée = kW 0,240
Pouvoir d'interruption de l'interrupteur général = 6 kA (230/400V)
Pour les caractéristiques techniques de l'interrupteur général voir section 15-ANNEXES.

-Appuyer sur le BOUTON D'ARRET D'URGENCE VERROUILLABLE.
-L'interrupteur principal magnétothermique est normalement sur la position OFF.
-Relier le câble fourni avec la machine à une prise conforme aux normes en vigueur dans le pays de l'utilisateur.

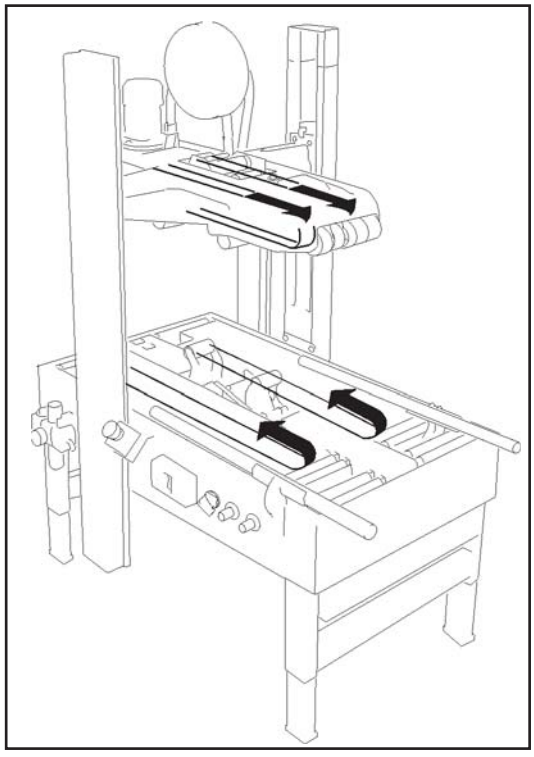
7.13 CONTROLE DES PHASES (UNIQUEMENT POUR COURANT TRIPHASE)

Procédure à suivre pour un enchaînement correct des phases:



- enlever les outils éventuels posés sur la machine.
- débloquer le bouton d'arrêt d'urgence à enclenchement, en le tournant dans le sens des aiguilles d'une montre.
- presser le bouton ON de l'interrupteur principal.
- contrôler, avant d'utiliser la machine, le sens de rotation des courroies d'entraînement.
- Au cas où elles tourneraient en sens contraire, inverser 2 phases sur les bornes de la prise de connexion.

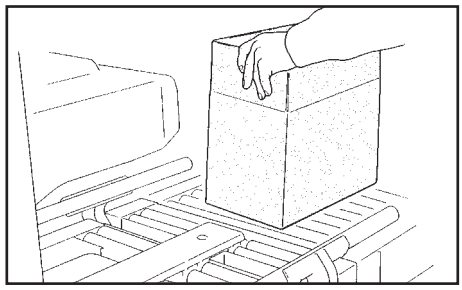
Sens de rotation des courroies d'entraînement.



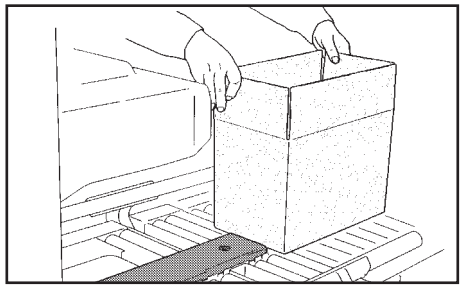
8-FONCTIONNEMENT

DESCRIPTION DU FONCTIONNEMENT

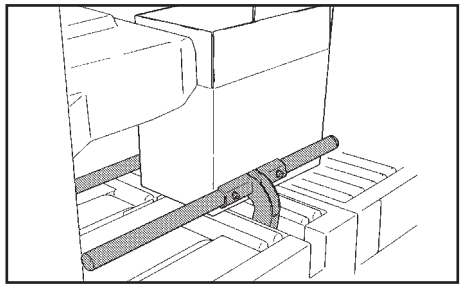
Plier manuellement les quatre rabats inférieurs de la boîte et mettre la boîte avec les rabats inférieurs pliés sur le plan de roulement.



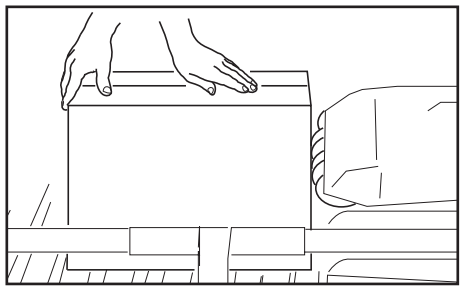
Tenir la boîte avec les mains et la faire avancer jusqu'elle appuie sur le levier qui contrôle la fermeture des guides.



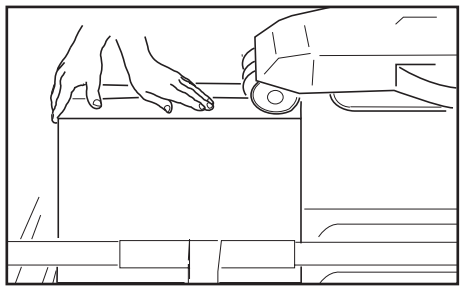
Les guides tienent la boîte ferme pour permettre le remplissage.



Après le remplissage, plier les quatre rabats supérieurs et pousser la boîte contre le levier à rouleau qui contrôle la montée de la tête.



Pousser la boîte dans la machine sur les courroies inférieures



8.2 DESCRIPTION DES MODES DE MARCHE

La machine enrubanneuse Mod. SR46-S fonctionne uniquement de façon automatique avec:

- bouton d'ARRET D'URGENCE non verrouillé;
- bouton de mise en marche ON.
- Circuit pneumatique en marche

8.3 DESCRIPTION DES MODES D'ARRET

8.3.1 ARRET NORMAL

En appuyant sur le bouton OFF de l'interrupteur général, on obtient l'arrêt immédiat de la machine en n'importe quelle phase du cycle.
Le même résultat est obtenu en interrompant l'alimentation du courant.
Le circuit pneumatique reste en fonction

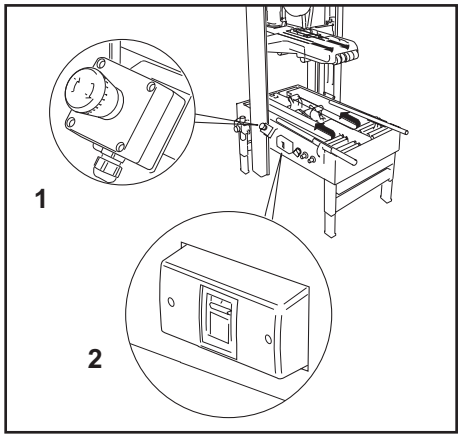
8.3.2 ARRET D'URGENCE

Poussoir verrouillable à forme de champignon pour l'arrêt d'urgence. (Cette pièce n'est pas fabriquée par le constructeur. Pour ses caractéristiques techniques voir section**15-ANNEXES**)

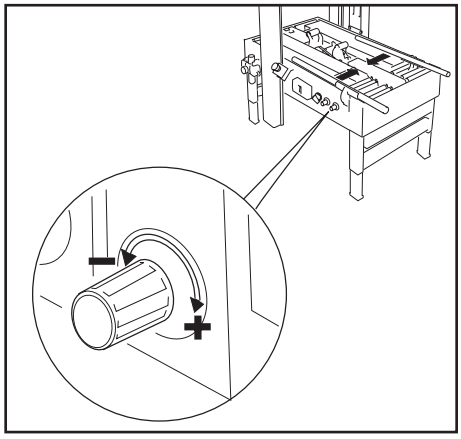
9-COMMANDES

9.1 BOUTON-POUSSOIR MARCHE / ARRET (2)
Met en mouvement / arrête les courroies de transmission des la boîte.

BOUTON ARRET D'URGENCE (1)
Arrête le cycle de la machine.

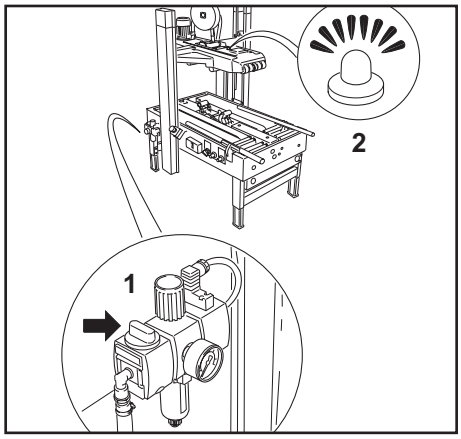


9.2 BOUTON REGLAGE PRESSION GUIDES
Il règle la pression des guides contre la boîte.

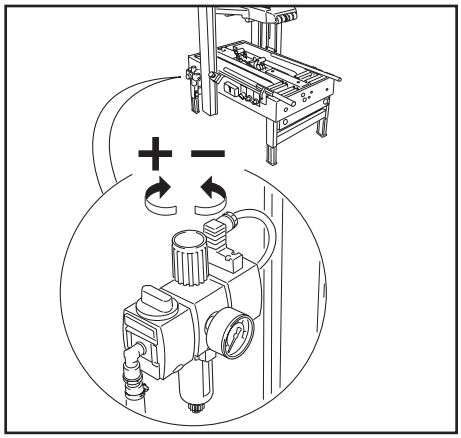


9.3 VALVE D'ALIMENTATION CIRCUIT PNEUMATIQUE (1)
Active / désactive le circuit pneumatique.

TÉMOIN PRESSION AIR (2)
Indique la présence d'air dans le circuit (voyant rouge allumé).

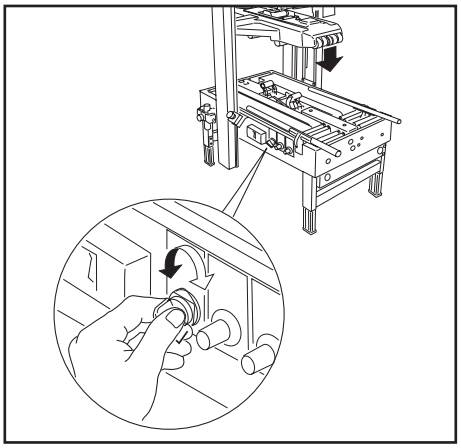


9.4 BOUTON DE RÉGLAGE PRESSION CIRCUIT PNEUMATIQUE
Augmente / diminue la pression dans le circuit.



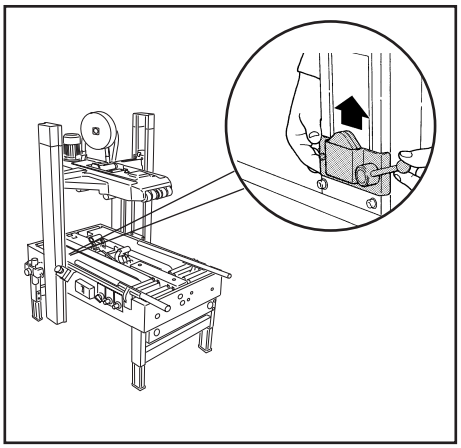
9.5 SÉLECTEUR MONTÉE / DESCENTE DE LA TETE

Fait monter / descendre la tête supérieure.



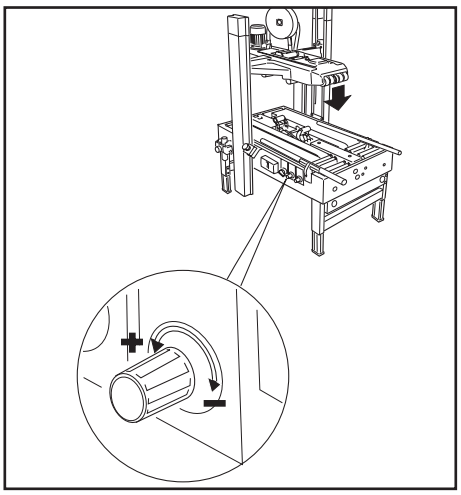
9.6 BLOQUE LA HAUTEUR DE LA TETE

Sert à positionner la tête supérieure en fonction de la boîte la plus basse..



9.7 BOUTON RÉGLAGE PRESSION TETE

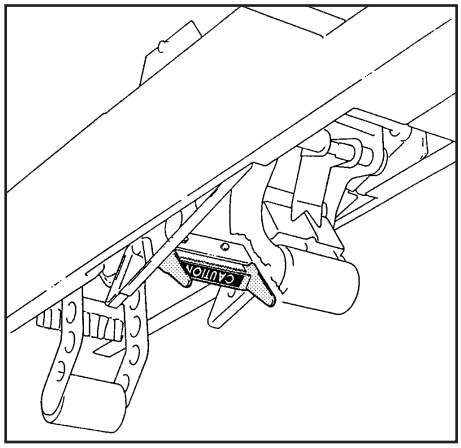
Augmente / diminue le poids de la tête supérieure sur la boite.



10-DESCRIPTION DES SYSTEMES DE SECURITE DE LA MACHINE

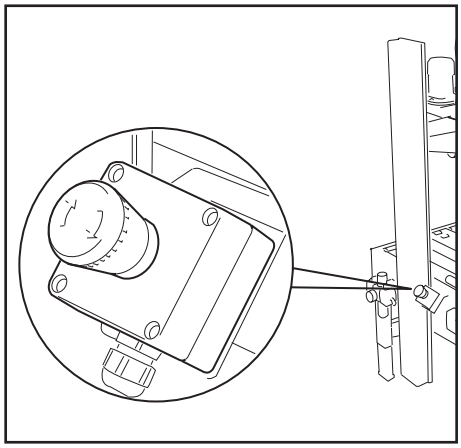
10.1 PROTECTION DES LAMES

La lame des unités enrubanneuses est protégée par un dispositif à ressort.



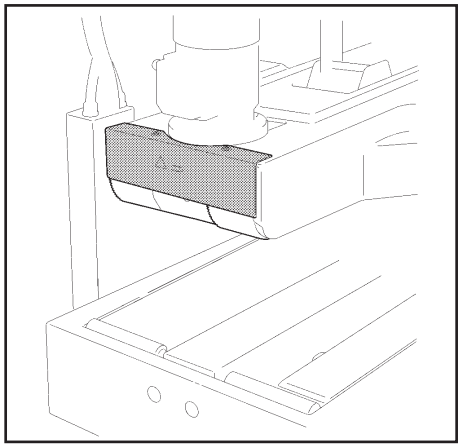
10.2 ARRET D'URGENCE

Le poussoir d'arrêt d'urgence verrouillable est placé en position facilement accessible, à la hauteur de la main qui ferme les rabats.



10.3 PROTECTION EN METAL

Protection des courroies d'entraînement supérieures.

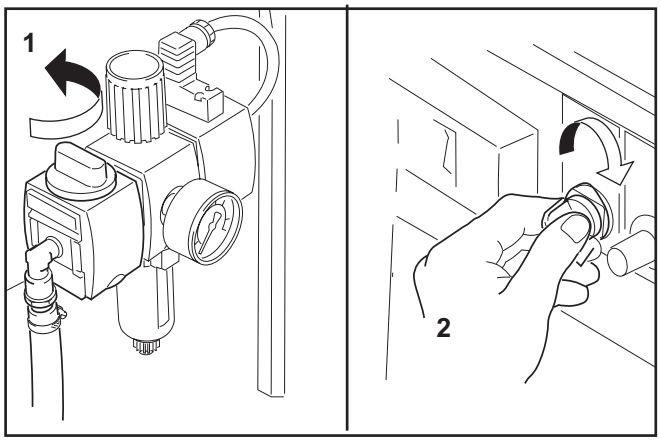


10.4 SYSTEME ELECTRIQUE

Le système électrique est protégé par un fil de mise à la terre dont la continuité a été dûment contrôlée et testée en phase de vérification finale, de même que l'isolation et la rigidité diélectrique des installations.
(Voir section **ANNEXES 15.5**)

11.0 SÉCURITÉ

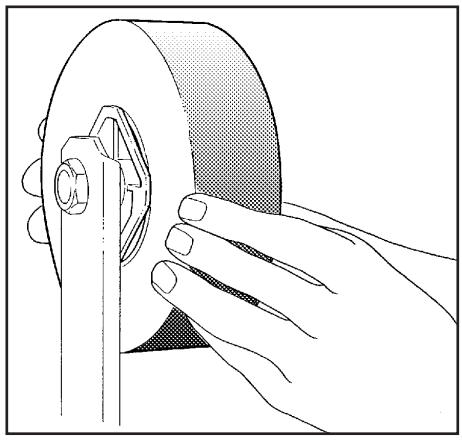
Toutes les opérations préalables à l'utilisation doivent être effectuées avec la machine à l'arrêt et le bouton d'ARRET D'URGENCE enclenché et verrouillé.



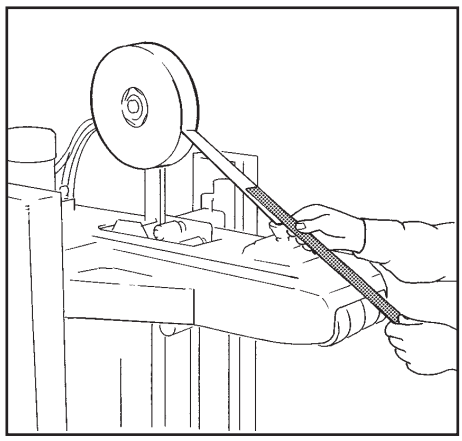
11.1 MONTAGE DU RUBAN DANS L'UNITÉ ENRUBANNEUSE SUPÉRIEURE

Activer le circuit pneumatique en tournant la poignée **1** dans le sens contraire aux aiguilles d'une montre et soulever la tête en tournant le sélecteur **2** dans les sens des aiguilles d'une montre.

Positionner une bobine de ruban sur le porte-rouleau en ayant soin de pousser à fond la bobine contre le porte-rouleau.

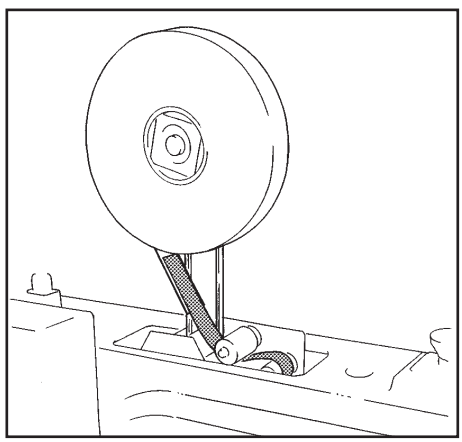


Coller le ruban sur l'outil spécial tire-ruban.

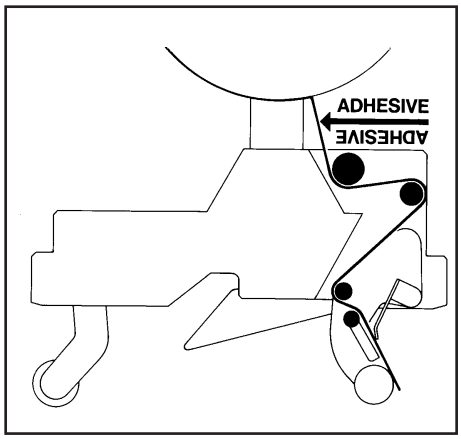


ATTENTION! Lames très tranchantes, susceptibles de causer de graves blessures.

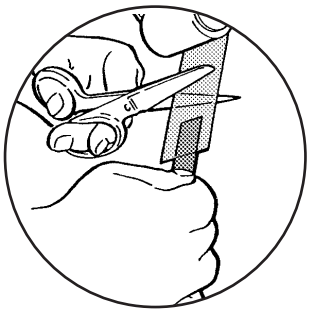
Insérer le tire-ruban dans l'unité d'enrubannage en ayant soin de garder les mains hors de portée des lames coupe-ruban (**voir 3.11-g**).

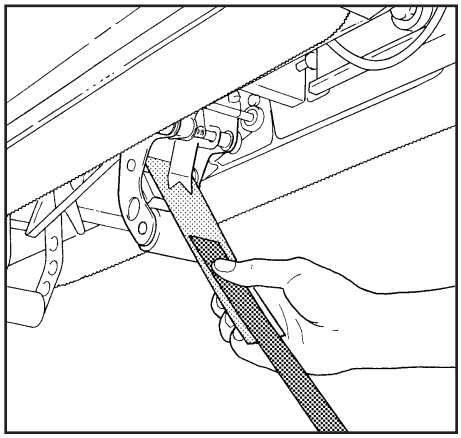


Faire suivre au ruban le parcours indiqué sur la figure en veillant à ce que le côté adhésif soit placé comme l'indique la flèche.



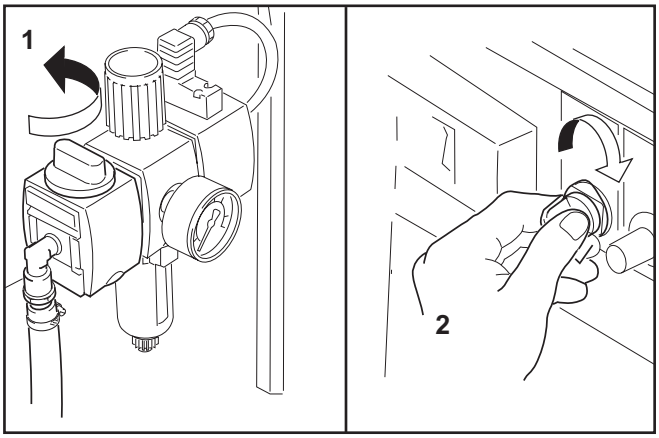
Tirer et couper le ruban qui dépasse à l'aide de ciseaux.



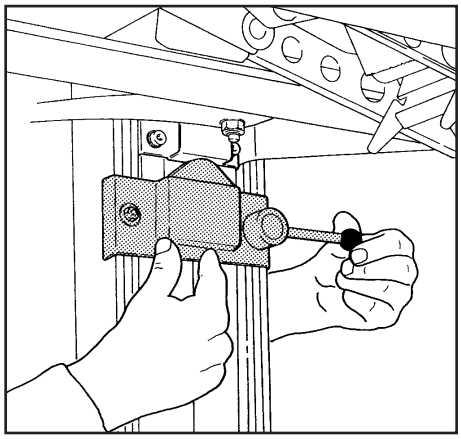


11.2 MONTAGE DU RUBAN DANS L'UNITÉ ENRUBANEUSE INFÉRIEURE

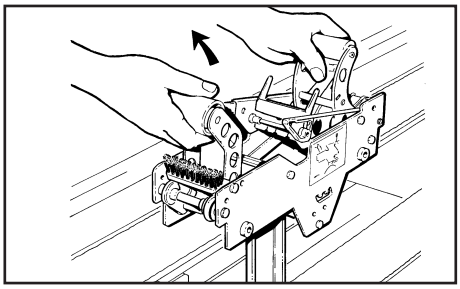
Activer le circuit pneumatique en tournant la poignée **1** dans le sens contraire aux aiguilles d'une montre et soulever la tête en tournant le sélecteur **2** dans le sens des aiguilles d'une montre.



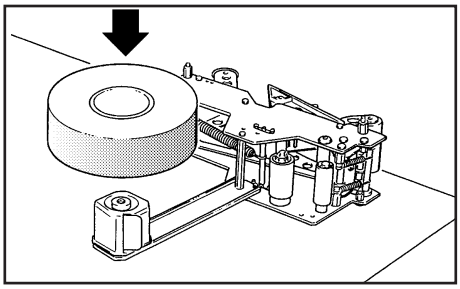
Soulever la butée fin-course centre la tête supérieure et la bloquer avec la levier. Après avoir changé le rouleau, reporter la butée dans sa position originale.



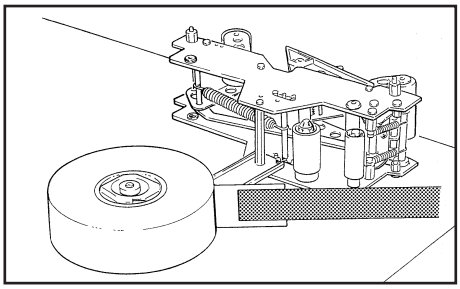
Dégager l'unité d'enrubannage et la poser sur un plan de travail.



Positionner une bobine de ruban sur le porte-rouleau.

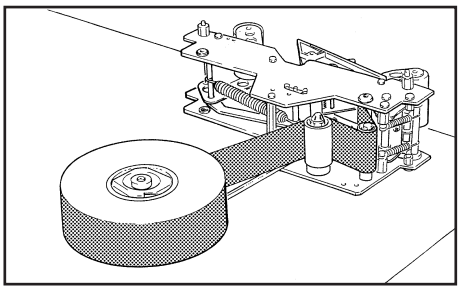


ATTENTION! Lames très tranchantes, susceptibles de causer de graves blessures.

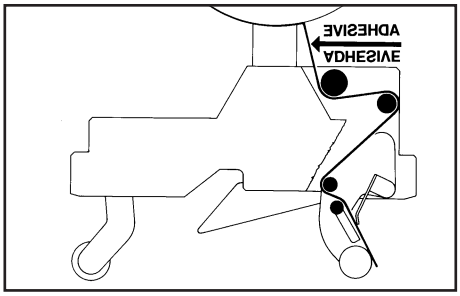


Coller l'extrêmité de la bande au tire-ruban.

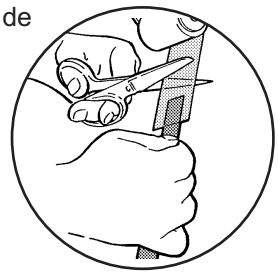
Insérer le tire-ruban dans l'unité d'enrubannage en ayant soin de garder les mains hors de portée des lames coupe-ruban (voir 3.11-g).



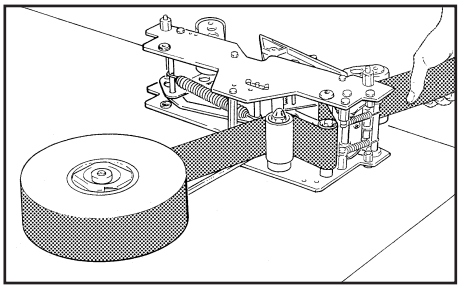
Faire suivre au ruban le parcours indiqué sur la figure en veillant à ce que le côté adhésif soit placé comme l'indique la flèche.



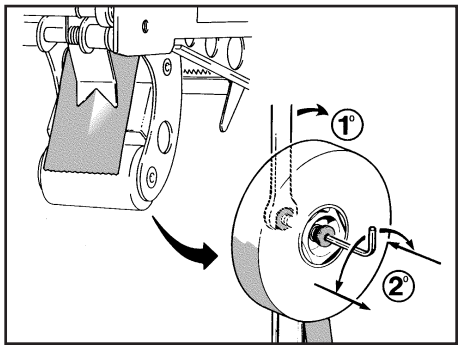
Tirer et couper le ruban qui dépasse à l'aide de ciseaux.



Remettre l'unité d'enrubannage à sa place.

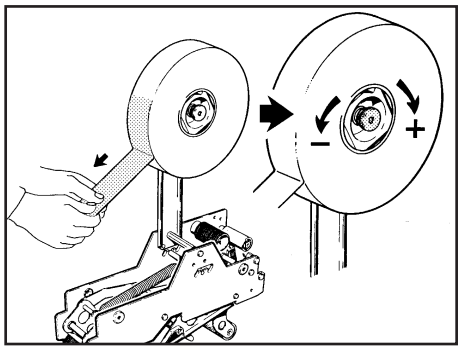


11.3 RÉGLAGE DU PORTE ROULEAU



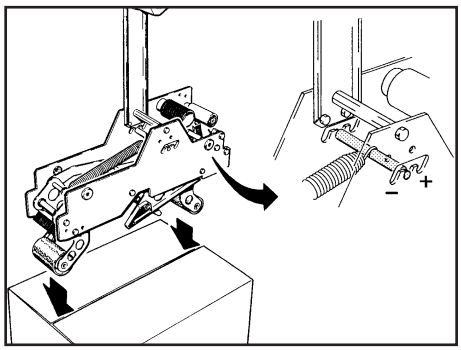
☞ Vérifier le centrage du ruban sur les rouleaux de l'unité .
Si nécessaire débloquer l'écrou **1** et régler la vis **2**.

11.4 REGLAGE DE LA FRICTION DU RUBAN



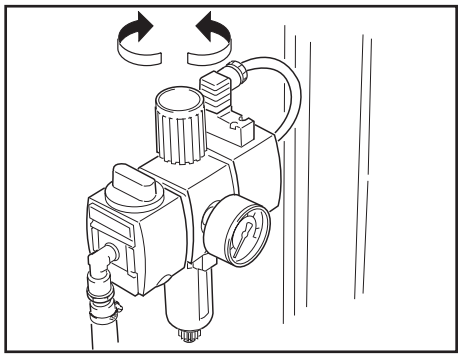
☞ Vérifier la tension du ruban:
- s'il est en PVC, le porte-rouleau doit être libre;
- s'il est en OPP, le porte-rouleau doit présenter une légère friction.

11.5 REGLAGE DES UNITES D'ENRUBANNAGE SUIVANT LE TYPE DE BOITES



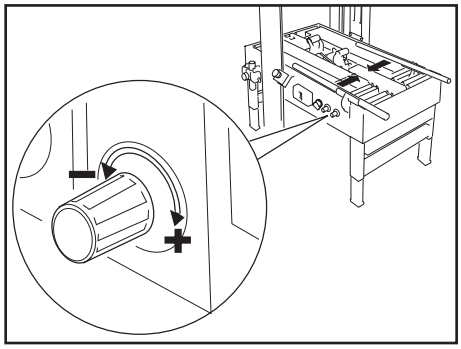
☞ Regler le ressort principal:
- pour les boîtes légères, alléger la pression du ressort ;
- pour les boîtes robustes, augmenter la pression du ressort.

11.6 REGULATEUR DE PRESSION



☞ Régler la pression en fonction de l'épaisseur du carton.
Pression maxi **6 Bar**.

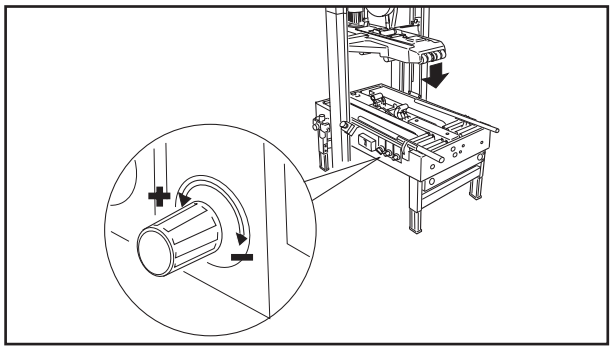
11.7 REGLAGE PRESSION GUIDES



Régler la pression des guides contre la boîte.
☞ Diminuer pour cartons légers; augmenter pour cartons lourds.

11.8 REGLAGE PRESSION TETE SUPERIEURE

Régler la pression de la tête supérieure sur la boîte.
Diminuer pour cartons légers ou en peu vides; augmenter pour cartons lourds ou trop pleins.

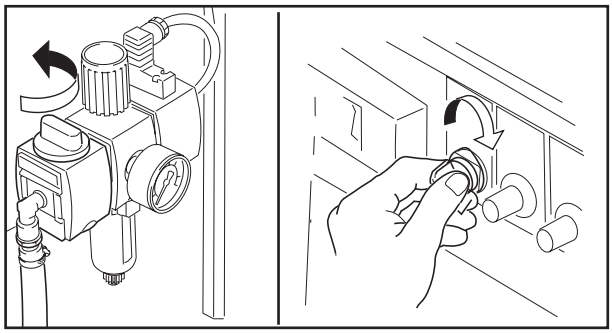


11.9 REGLAGE VITESSE DE DESCENTE TETE SUPERIEURE

En conditionnes normales de travail, la tête descende jusqu'au 110 mm après avoir terminé la fermeture.
Il est possible de limiter la descente quand:

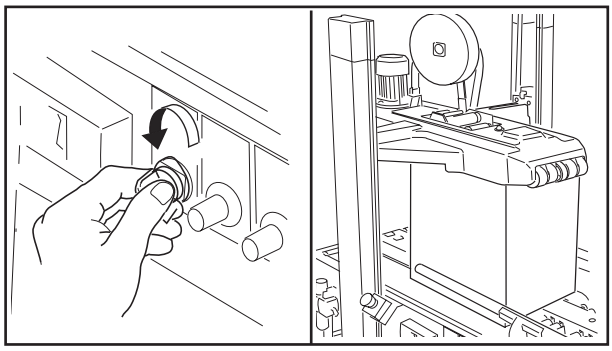
a) on connait la hauteur minimale des boîtes à fermer.
b) on doit fermer une série de boîtes à fermer.

Pour régler la hauteur minimale de la tête, faire comme suit:

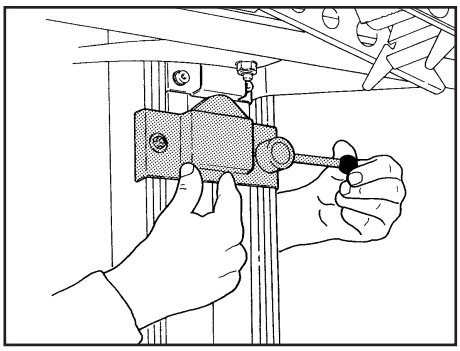


Tourner le sélecteur dans le sens des aiguilles d'une montre pour soulever la tête supérieure.

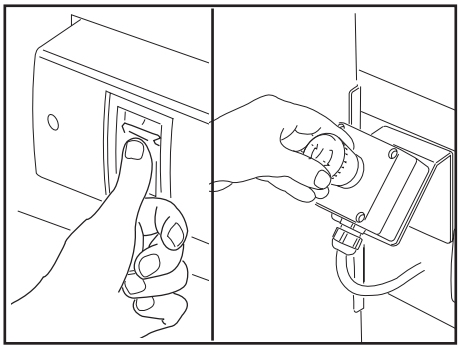
Introduire la boîte et tourner le sélecteur dans le sens contraire aux aiguilles d'une montre pour faire descendre la tête dur la boîte.



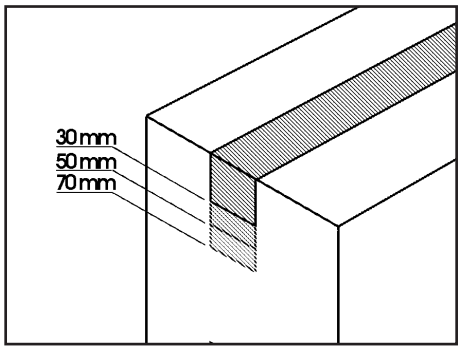
Soulever l'arrêt vers la tête supérieure et le bloquer avec le levier.



Tourner le bouton d'arrêt d'urgence dans le sens des aiguilles d'une montre et presser le bouton ON.
La boîte serait prise par les courroies, fermée avec le ruban et expulsée de la machine.



REGLAGES SPECIAUX

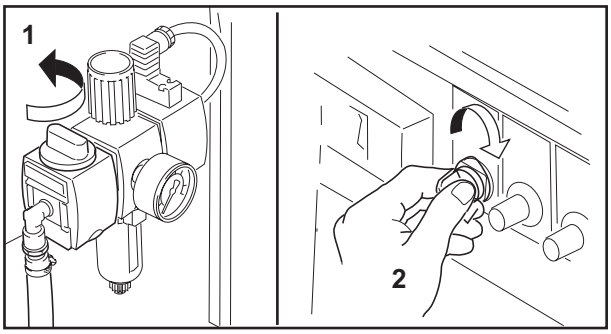


11.10 MODIFICATION DE LA LONGUEUR DU LIMBE DU RUBAN

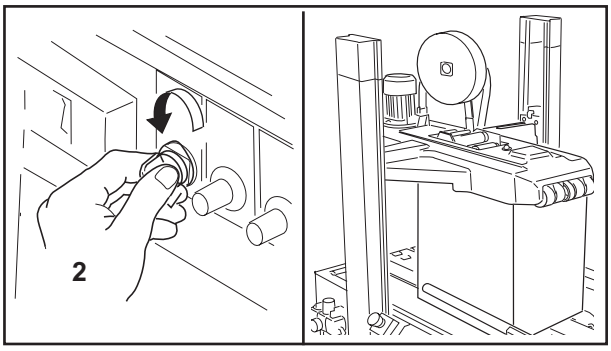
La longueur du limbe du ruban peut varier de 70 à 50 à 30 mm.
Pour ce type de réglage , se référer au manuel de l'unité enrubaneuse K12, joint avec la machine. .

COLONNES FIXES EN POSTION HAUTE

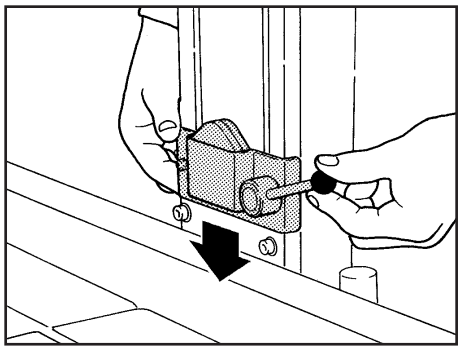
Pour pouvoir enrubaner des boîtes ayant des hauteurs supérieures à 500 mm et jusqu'à 550 mm il est nécessaire de soulever les colonnes de la machine.
Procéder comme suit:



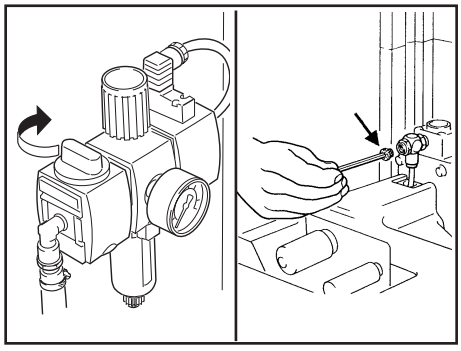
activer le circuit pneumatique en tournant dans le sens contraire aux aiguilles d'une montre la poignée **1** et soulever la tête supérieure en tournant le sélecteur **2** dans le sens des aiguilles d'une montre.



Insérir sous la tête une caisse (hauteur 450 mm environ) suffisamment rigide pour supporter le poids de la tête (45 kg).
Tourner le sélecteur **2** dans le sens contraire aux aiguilles d'une montre en faisant descendre la tête jusqu'à ce qu'elle se pose sur le support.



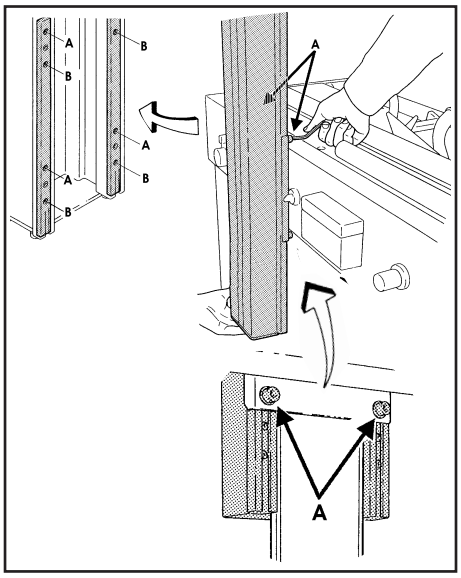
Débloquer et abaisser complètement l'arrêt.



Désactiver le circuit pneumatique en tournant la poignée dans le sens des aiguilles d'une montre.
Retirer le bouchon pour faire sortir complètement l'air du circuit pneumatique.

Revisser le bouchon.

Tenir avec une main la colonne et enlever les quatre vis **A** avec l'autre main; pousser la colonne vers le haut jusqu'à ce qu'elle soit à la hauteur trous **B**.
Remonter les vis. Réactiver le circuit pneumatique.

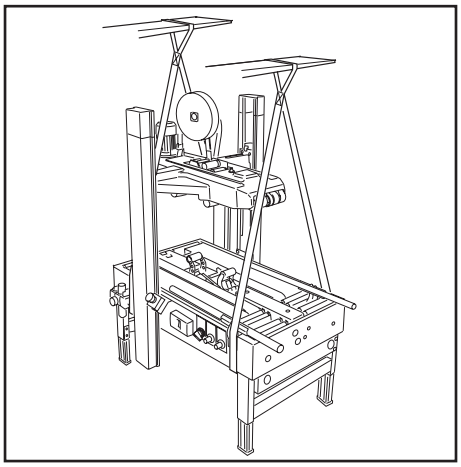


ACCESSOIRES EN OPTION

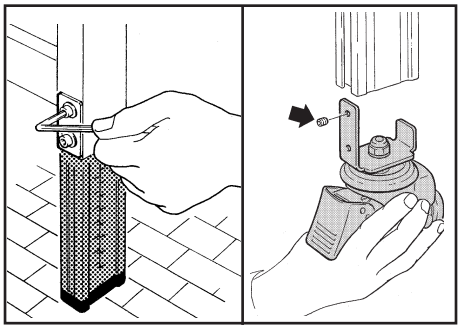
11.2 SET ROUES EN OPTION (AS77)
(Code set: 7.8.04337.00B)

Pour faciliter le déplacement de la machine il est possible d'y monter quatre roues ; en conséquence la hauteur du convoyeur et les dimensions générales varient (voir paragraph 4.7).

Soulever la machine comme illustré sur la figure.



Enlevez les pieds, emboitez les roues, fixez-les avec deux pivets et regulez l'hauteur plan conveyeurs, en utilisant l'échelle graduée. (Hauteur de la roue = 100 mm).

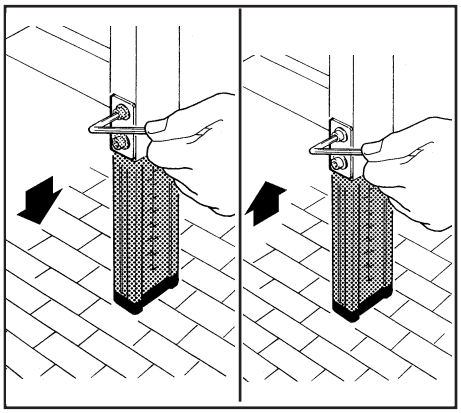


11.3 SET DE PIEDS EN OPTION H=600 (AS80)
(Code set: 7.8.04413.00A)

Pour avoir une plus grande gamme de reglage de la hauteur du plan de travail, comme indiqué à le paragraph 4.7, il est necessaire de remplacer les pieds avec les pieds AS80 plus longs.

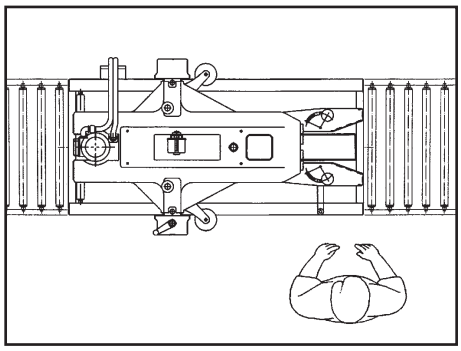
Soulever la machine comme illustré sur la figure
Débloquer les vis et faire glisser les pieds.

Fixer les nouveaux pieds et les bloquer en se référant à l'échelle graduée.



12-UTILISATION DE LA MACHINE

12.1 POSITION CORRECTE DE L'OPERATEUR



12.2 MISE EN MARCHE

Appuyer sur le ON de l'interrupteur principal après avoir désenclenché le bouton d'ARRET D'URGENCE.

12.3 MISE EN ROUTE DE LA PRODUCTION

Après avoir effectué le réglage de la machine en fonction des dimensions des boîtes (hauteur-largeur), faire tourner la machine à vide et contrôler le fonctionnement des dispositifs de sécurité (voir paragraphe 12.8) . Seulement après commencer le cycle.

12.4 REMPLACEMENT DU RUBAN

Faire très attention aux lames.

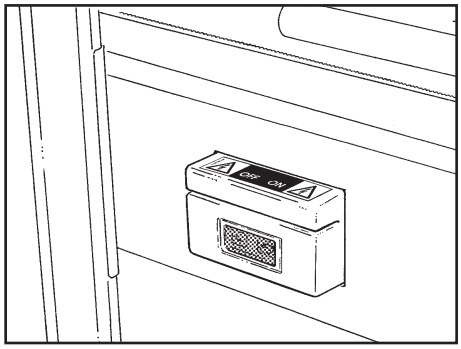
Opérateur de niveau de qualification 1

Procéder de la façon suivante pour le remplacement de la bobine:

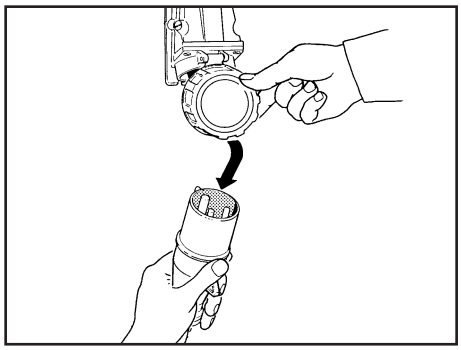
- Appuyer sur le bouton d'ARRET D'URGENCE verrouillable;
- Faire toutes les opérations indiquées aux 11.1 et 11.2

12.5 NETTOYAGE

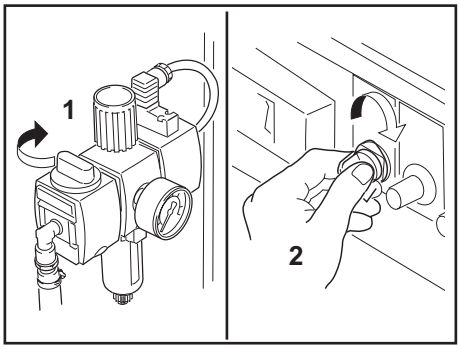
Avant de procéder à toute opération de nettoyage ou d'entretien, arrêter la machine en appuyant sur le bouton d'ARRET D'URGENCE (OFF) de l'interrupteur principal.



Débrancher la prise d'alimentation électrique.



Activer le circuit pneumatique en tournant la poignée **1** dans le sens contraire aux aiguilles d'une montre et soulever la tête supérieure en tournant le sélecteur **2** dans le sens des aiguilles d'une montre.
Bloquer la tête supérieure avec la butée fin-course (voir parag-11.2).



NETTOYAGE - Opérateur de niveau **1**
Utiliser des chiffons secs ou des solutions détergentes légères.

Ne jamais utiliser de solvants ou laver avec un jet d'eau.

12.6 TABLEAU RECAPITULATIF DES REGLAGES

OPERATIONS	OPERATOR'S SKILL	SECTIONS
Tape loading	1	11.1 - 11.2
Tape alignment	1	11.3
Checkout of the safety devices	1	12.7
Adjustment of tape drum friction brake	1	11.4
Adjustment of the upper head descent speed	1	11.9
Adjustment of tape applying spring	1	11.5
Conveyor bed height adjustment	1	7.4
Air pressure	1	11.6
Special adjustment: Tape leg	2	11.10
Special adjustment: Outer column in high position	2	11.11

12.7 CONTROLE DES DISPOSITIFS DE SECURITE

1 Protection des lames des unités d'enrubannage (paragraph 10.1)
2 Bouton d'arrêt d'urgence verrouillable (paragraph 10.2)
3 Bouton d'arrêt (OFF) de l'interrupteur principal (parag. 7.11.3 et parag. 9.1)

SITUATION	CAUSE	REMEDE
Le bouton ne s'enclenche pas quand on appuie sur ON et la machine ne part pas.	Bouton d'arrêt d'urgence enclenché. Court-circuit dans l'installation.	Desenclencher le bouton d'arret en le tournant dans le sens des aiguilles d'une montre. Effectuer un controle.
La protection magneto-thermique enclenche l'interrupteur general.	Moteur soumis à un trop grand effort. Reglage du fusible à une temperature trop basse dans l'interrupteur principal.	Verifier que les courroies ne sont pas bloquées. S'assurer que l'absorption de courant indiquée sur la plaquette des moteurs n'excede pas celle de l'interruptéur général.
Le moteur tourne mais les courroies d'entrainement s'arretent.	Tension des courroies insuffisante. Poulies usées.	Régler. Vérifier l'état des anneaux en plastique et les remplacer si necessaire.
Les courroies d'entrainement tournent mais la boîte ne bouge pas.	Courroies d'entrainement usées.	Les remplacer.
la tête supérieure ne descend pas ou descend trop lentement / rapidement.	Le sélecteur de montée / descente n'est pas enclenché. Il a été modifié le réglage d'origine	Tourner dans le sens contraire aux aiguilles d'une montre. Régler la pression.

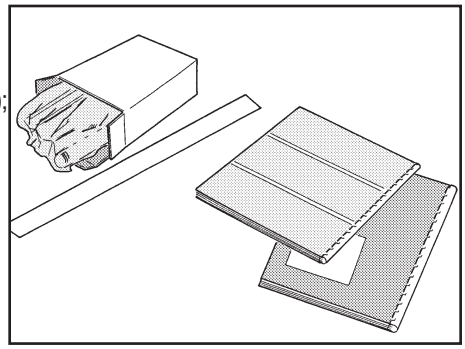
13- ENTRETIEN ET RIPARATION

13.0 SECURITE

(Voir section 3)

L'exécution des opérations d'entretien et de réparation peut présenter des dangers. Cette machine a été conçue en tenant spécifiquement compte des normes de la loi.

13.1 ACCESSOIRES ET PIECES FOURNIS AVEC LA MACHINE



1 N.1 lame (Lame de rechange pour l'unité d'enrubannage, cod. S404152ZZZ);
N. 1 ressort principal pour la tête inférieure (cod. S370017992Z);
N. 1 ressort principal pour la tête supérieure(cod. S370017894Z);
N. 2 ressorts pour le porte-lame(cod. S37022794Z);
2 Tire-ruban (pour insérer le ruban dans les unités, cod. S310091406Z);
3 Manuel de la machine(cod. SMB00049K)
4 Manuel de l'unité enrubanneuse (cod. S300024296A).

13.2 NATURE ET FREQUENCE DES VERIFICATIONS ET DES OPERATIONS D'ENTRETIEN

OPERATIONS	FREQUENCE	QUALIFICATION DE L'OPERATEUR	SECTION
Lubrification	Trimestrielle	**2**	**13.5-6-7**
Nettoyage des lames	Hebdomadaire	**2**	**13.8**
Nettoyage de la machine	Hebdomadaire	**1**	**12.5**
Contrôle des dispositifs de sécurité	Quotidienne	**1**	**13.4**
Remplacement des lames	//	**2**	**13.9**
Remplacement des courroies	//	2	**13.10**

13.3 VERIFICATIONS A EFFECTUER AVANT ET APRES CHAQUE OPERATION D'ENTRETIEN

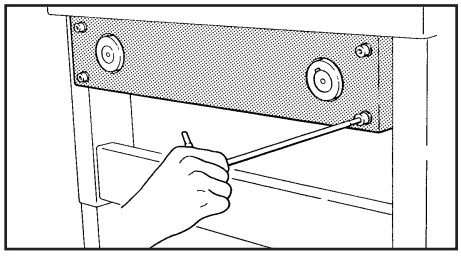
Appuyer sur le bouton OFF de l'interrupteur principal et enlever la prise du tableau général avant chaque opération d'entretien.
(pag. 61)
Durant toute la phase de l'entretien, seule la personne chargée de celui-ci doit avoir accès à la machine.
Au terme de chaque opération d'entretien, contrôler l'état de fonctionnement de tous les dispositifs de sécurité et de prévention des accidents.

13.4 CONTROLE DES DISPOSITIFS DE SECURITE

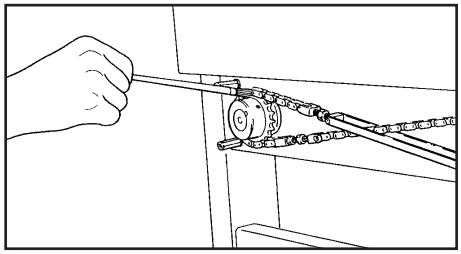
1 Protection des lames des unités d'enrubannage (paragraph 10.1)
2 Bouton d'arrêt d'urgence verrouillable (paragraph 10.1)
3 Bouton d'arrêt (OFF) de l'interrupteur principal (para. 7.11.3 et para 9.1)

13.5 LUBRIFICATION DE LA MACHINE

Enlever le couvercle.

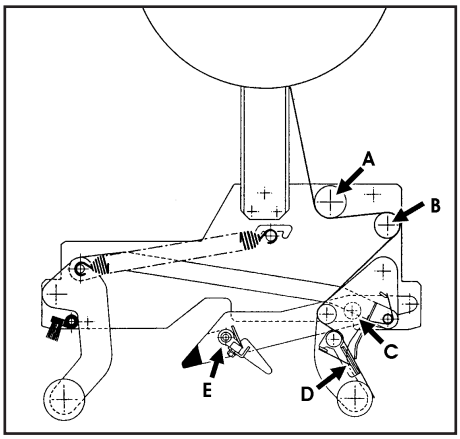


Lubrifier la chaîne et les pignons trimestriellement avec de la graisse pour métal sur métal.



13.6 PRODUITS POUR LA LUBRIFICATION

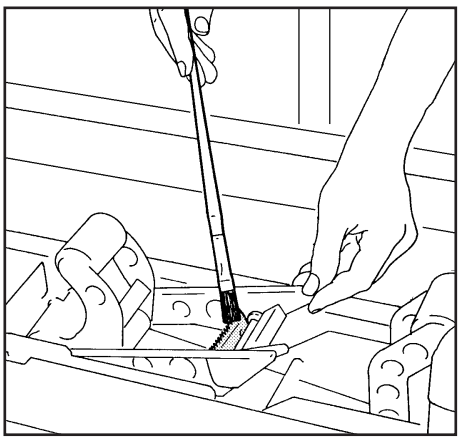
GRAISSE TYPE:
METAL/METAL: B.C. 19O HEAVY DUTY
(ou bien graisse pour chaînes ou roulements)
METAL/PLASTIQUE: PLATE MASTER M+L
(graisse au molybdène et PTFE pour matières plastiques et métal)
HUILE:
huile normale lubrifiante.



13.7 LUBRIFICATION DES UNITES ENRUBANNEUSES

Lubrifier chaque mois les points indiqués à la figure avec de l'huile lubrifiante normale.

A tige de fixation de ressort
B tige tendeur de ressort
C tige rouleau anti-retour
D charnière porte-lame
E tige de protection de la lame

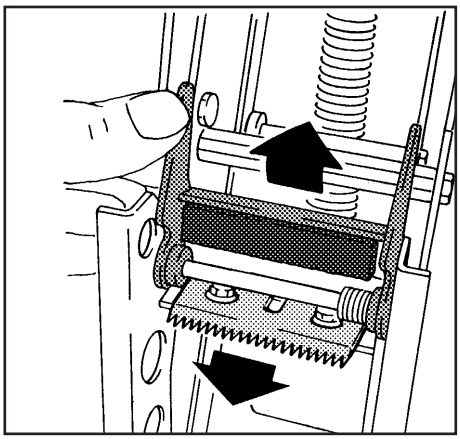


13.8 NETTOYAGE DES LAMES

Opérateur de niveau de qualification **2**
Soulever la protection et nettoyer la lame avec un pinceau (à long manche) et de l'huile. L'huile évite l'accumulation de résidus adhésifs.

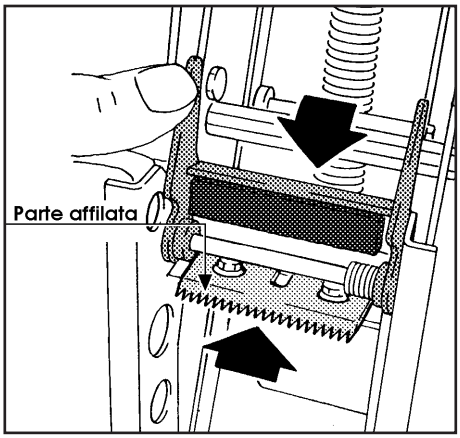
13.9 REMPLACEMENT DES LAMES

Opérateur de niveau de qualification 2.
- Soulever la protection de la lame suivant les indications de la Figure.
- Desserrer les vis.
- Enlever la lame.



ATTENTION!
La lame est très tranchante.
Des erreurs au cours de cette opération peuvent provoquer des blessures graves.

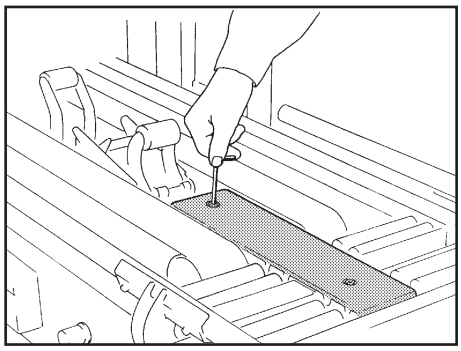
- Introduire la nouvelle lame en faisant très attention à la position de la partie tranchante.
- Bloquer les vis.
- Remettre la protection



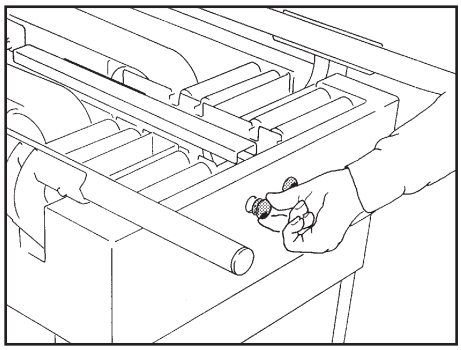
13.10 REMPLACEMENT DES COURROIES D'ENTRAINEMENT INFÉRIEURES

Qualification opérateur 2

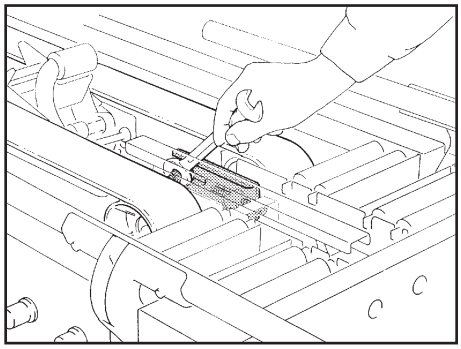
- Enlever les quatre vis.
- Enlever le carter.



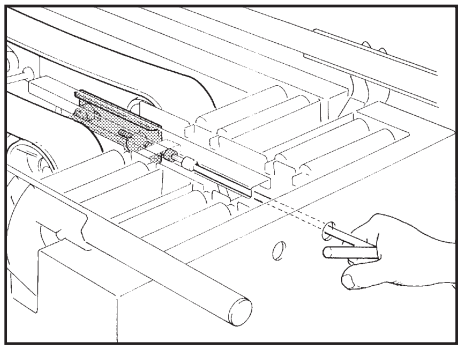
- Enlever les deux bouchons.



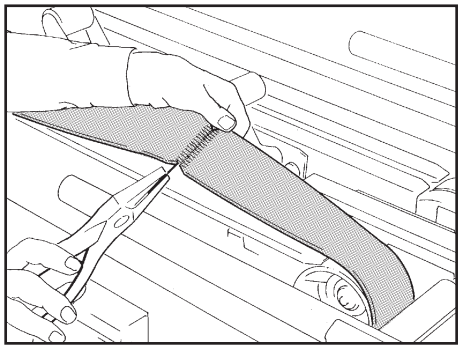
- Desserrer l'écrou de bloquage.



- Desserrer la vis de réglage de la tension.



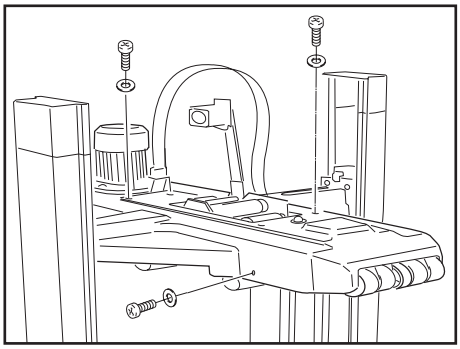
- Couper la courroie usée avec un cutter.
- Positionner la nouvelle courroie.
- Insérir entre les points de jonction une tige en nylon.
- Régler la tension de la courroie.



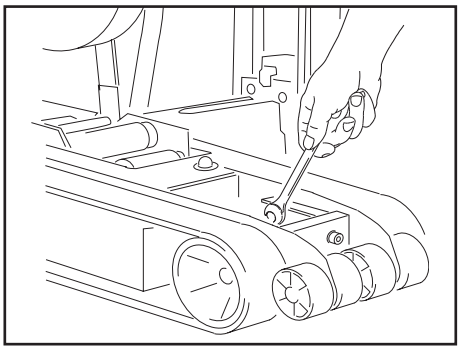
13.11 REMPLACEMENT DES COURROIES D'ENTRAINEMENT SUPÉRIEURES

Qualification opérateur **2**

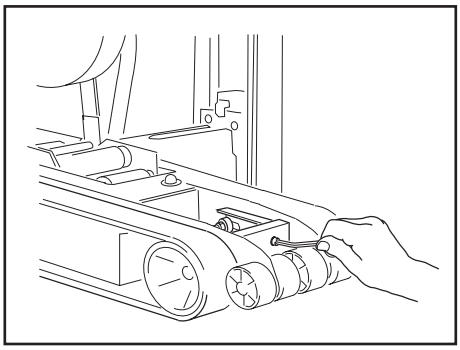
-Enlever les dix vis, qui fixent le carter et le retirer de son logement.



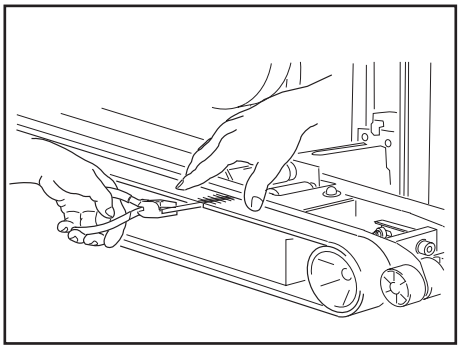
- Dévisser le boulon de bloquage.



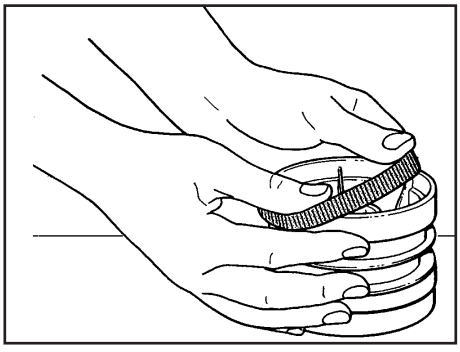
- Dessérrer la vis de tension.



- Couper la courroie usée avec un cutter.
- Positionner la nouvelle courroie.
- Insérir entre les points de jonction une tige en nylon.
- Régler la tension de la courroie.

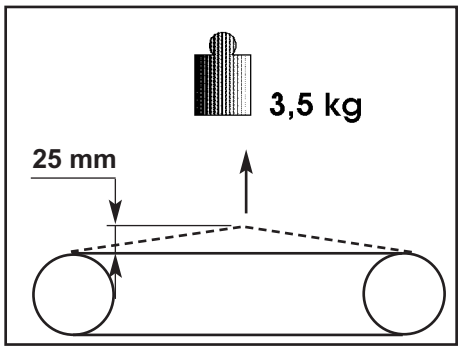


ATTENTION!
Avant d'insérer la nouvelle courroie, contrôler l'état des anneaux en plastique orange sur les poulies motrices: si ils sont usés, les remplacer.



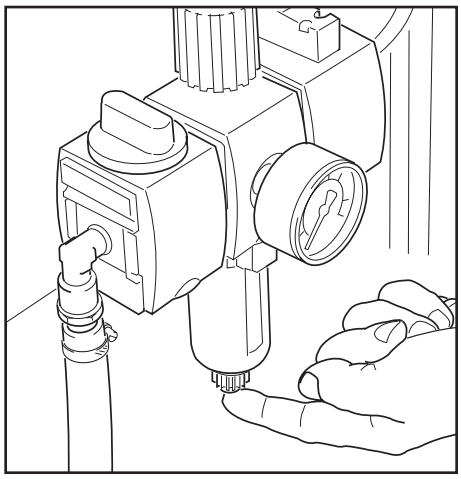
13.12 REGLAGE DE LA TENSION DES COURROIES

Contrôler la tension de la courroie en la soulevant au centre; elle doit marquer un écart de 25 mm environ avec une traction de 3,5 kg.



IMPORTANT !

Chaque fois que s'accumule de la condensation dans le filtre, la faire évacuer en effectuant une légère pression sur la partie inférieure du gobelet comme indiqué sur la figure.



13-ENTRETIEN ET RIPARATION

REGISTRE DES OPERATIONS DE REPARATION EFFECTUEES SUR LA MACHINE

Date	Description des operations

14- INSTRUCTIONS COMPLEMENTAIRES

14.1 INDICATIONS POUR LA MISE A LA FERRAILLE ET L'ELIMINATION DE LA MACHINE

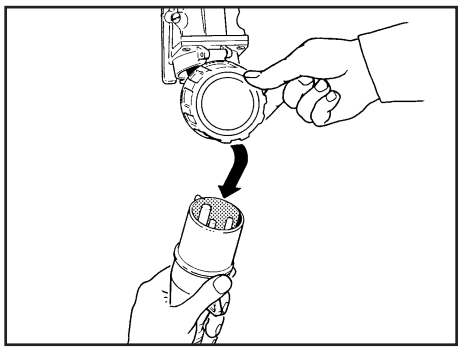
La machine est constituée de:

- une structure en acier;
- rouleaux transporteurs en Nylon;
- courroies d'entraînement en PVC;
- poulies en Nylon.

Pour l'élimination de ces matériaux, l'utilisateur se conformera aux dispositions législatives en vigueur dans son pays.

14.2 INSTRUCTIONS POUR LES CAS D'URGENCE

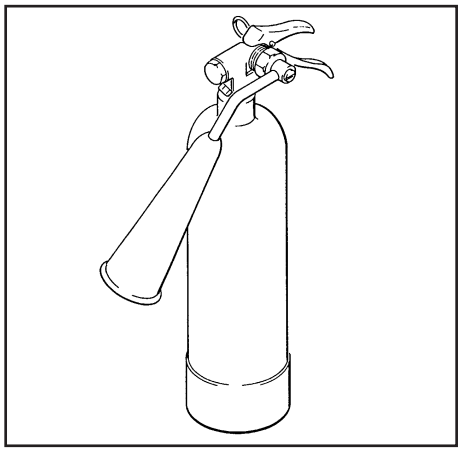
En cas de danger ou d'incendie, débrancher la prise du tableau général.



INCENDIE

En cas d'incendie, utiliser un extincteur contenant du CO2

Ne pas utiliser eau.



15- ANNEXES

15.1 DECLARATION DE CONFORMITE

avec la directive 98/37 CEE, 91/368, 93/44 et 93/68.

15.2 SIGNALÉTIQUE DES DISPOSITIFS DE SÉCURITÉ

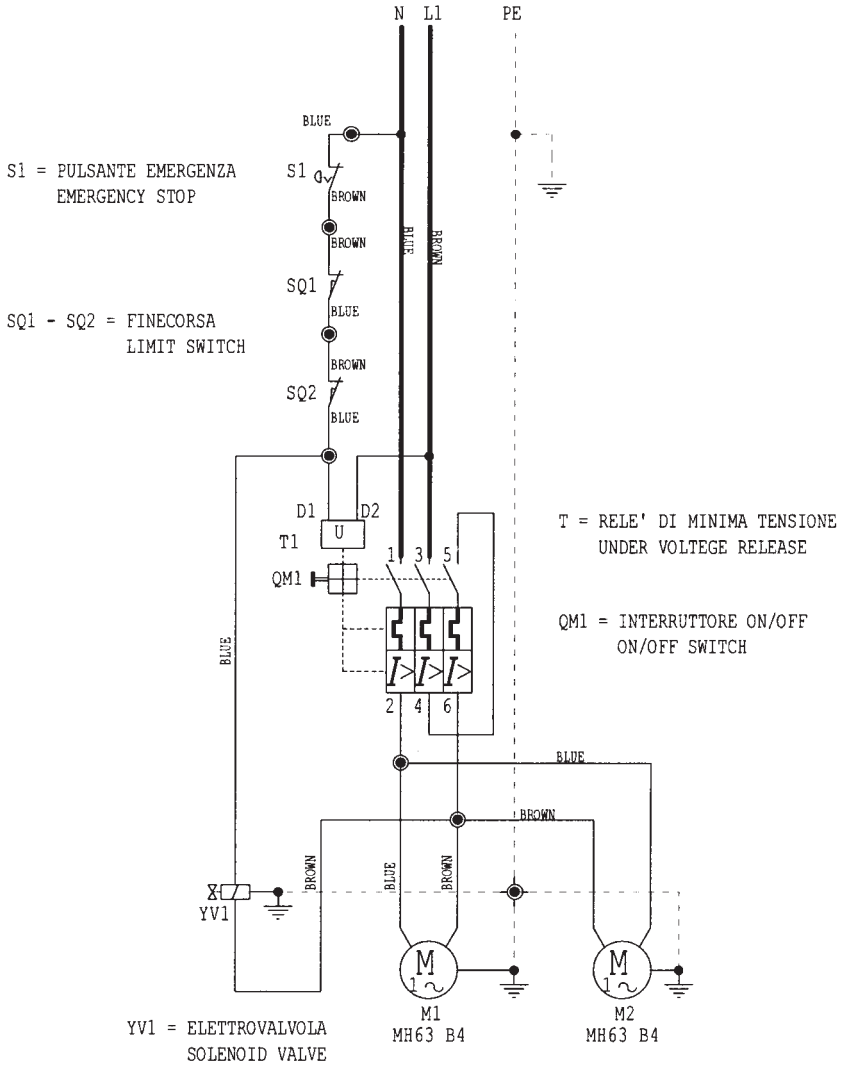
Les étiquettes appliquées sur la machine sont importantes pour la sécurité de l'opérateur.
En cas de détérioration ou d'absence d'une étiquette, l'utilisateur est tenu de la remplacer immédiatement.
Pour commander les étiquettes de rechange, vous êtes priés de faire référence aux codes reportés sur la figure 5709 du catalogue des pièces de rechange.

15.3 INDICATIONS SUR LES EMISSIONS DE RADIATIONS, DE GAZ, DE VAPEURS ET DE POUSSIERES

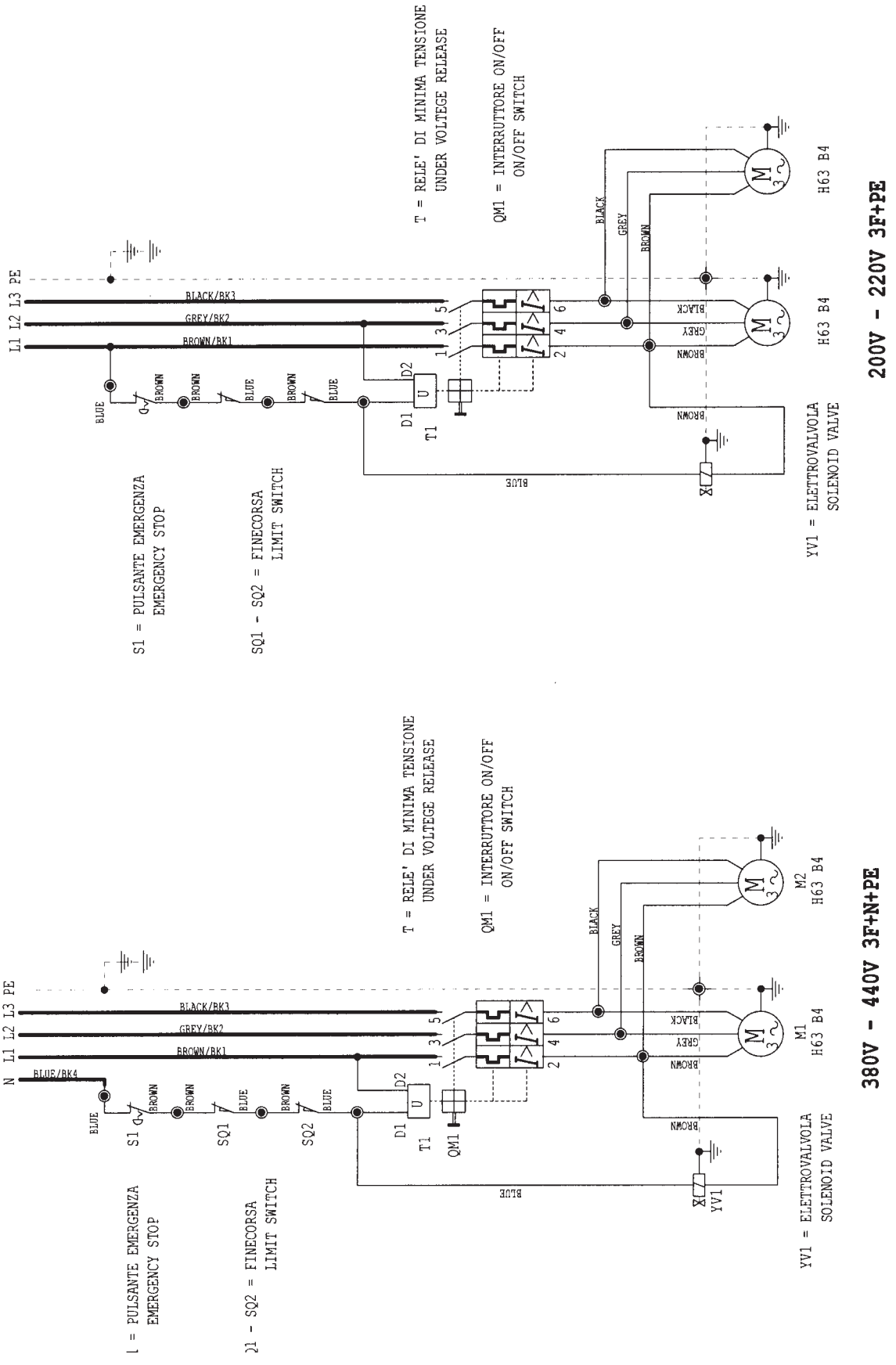
Rien à signaler.

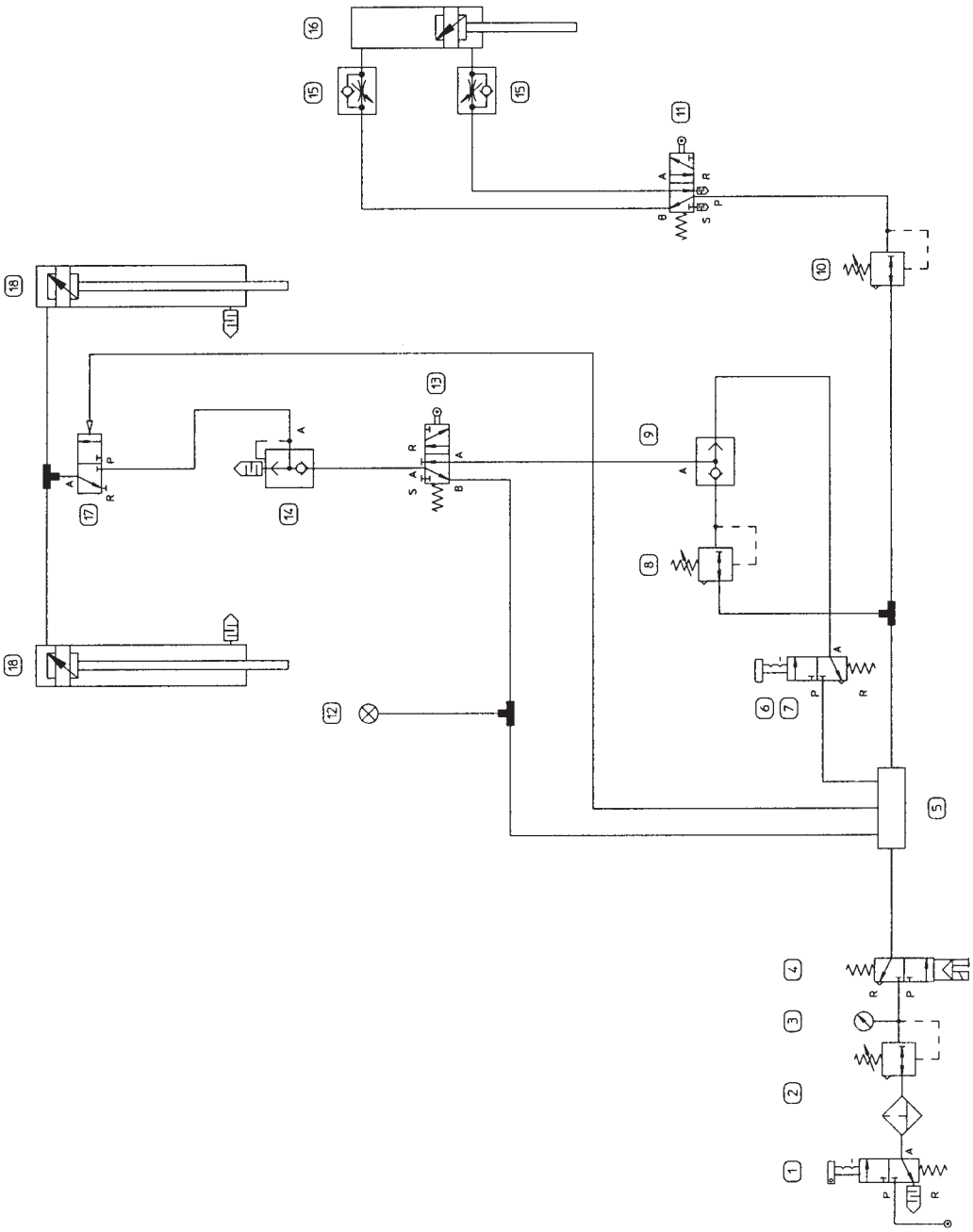
15.4 VERIFICATIONS ELECTRIQUES

Contrôles effectues:
1 - Continuité du circuit de protection
2 - Résistance d'isolement
3 - Tension d'isolement
Références EN 60204-1, Paragr. 20.2, 20.3, 20.4



100V - 240V MF+PE


200V - 220V 3F+PE
L1 L2 L3 PE
BLACK/BK3
GREY/BK2
BROWN/BK1
T = RELE' DI MINIMA TENSIONE
UNDER VOLTEGE RELEASE
QM1 = INTERRUTTORE ON/OFF
ON/OFF SWITCH
S1 = PULSANTE EMERGENZA
EMERGENCY STOP
SQ1 - SQ2 = FINECORSA
LIMIT SWITCH
YV1 = ELETTROVALVOLA
SOLENOID VALVE
H63 B4
380V - 440V 3F+N+PE
N L1 L2 L3 PE
BLUE/BK4
M1
M2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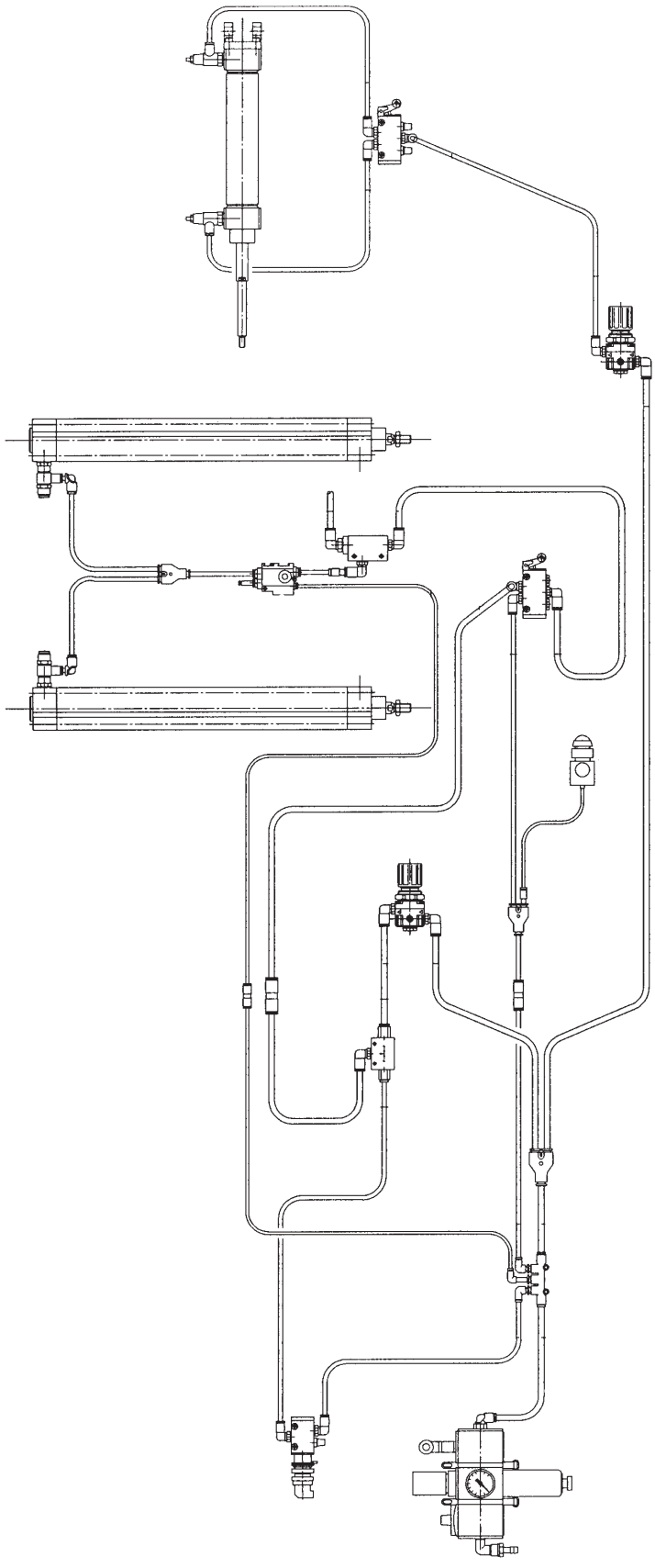

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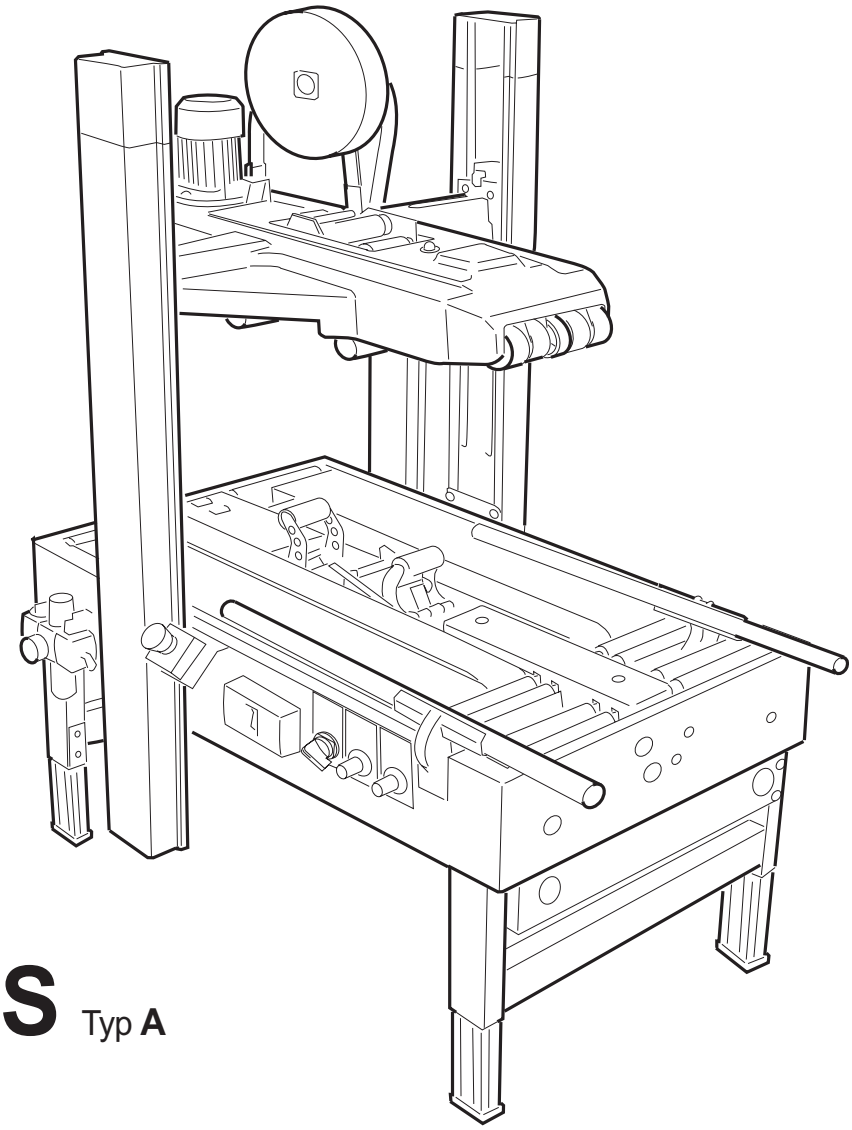

SR46-S Typ **A**

NASTRATRICE AUTOMATICA
AUTOMATIC CASE SEALING MACHINE
MACHINE ENRUBANNEUSE AUTOMATIQUE
AUTOMATISCHE KARTONVERSCHLIESSMASCHINE
PRECINTADORA AUTOMATICA

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO
INSTRUCTIONS MANUAL AND SPARE PARTS LIST
MANUAL D'INSTRUCTIONS ET PIECES DETACHEES
BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE
MANUAL DE INSTRUCCIONES Y RECAMBIOS

CE

Publikation Nr: SMB00049K

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http://www.siat.com - E-Mail: siat@siat.com

Bedienungsanleitung für verwendung, sicherheit, wartung sowie ersatzteilliste für die kartonverschliessmaschine SR46-S typ A.

Veröffentlichung Eigentum der SIAT S.p.A.
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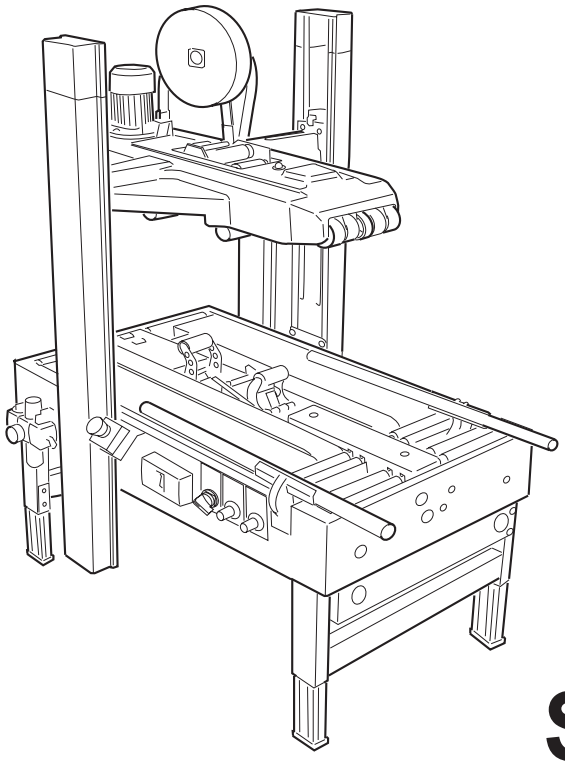
Technische Änderungen jederzeit vorbehalten.

Publikation Nr. SMB00049K
Überarbeitung I



SR46-S Type **A**

AUTOMATISCHE KARTONVERSCHLIESSMASCHINE MIT OBEREM UND UNTEREM FÖRDERBANDANTRIEB

- Maximale Schachtelgröße h. 750 mm x w. 650 mm
- Klebeband 75 mm
- Fördergeschwindigkeit der Schachteln 22 m / Min.
- Durchschnittl. Produktion 650 Schachteln / Stunde

	Kapitel
Fabrikationsnormen	1.1
Betriebsanleitung, deren Gebrauch	1.2
Matrikelnummer	2.1
Technischer Service	2.2
Garantie	2.3
Sicherheit	3
Qualifikation d. Bedienungspersonals	3.6
Technische Daten	4
Abmessungen und Gewicht	4.2.-4.6
Lärmemission	4.10
Transport	5
Auspacken	6
Aufstellung	7
Betrieb	8
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Inbetriebnahme	12
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Fehlerdiagnose	12.8
Wartung	13
Schmierung	13.5
Messeraustausch	13.9
Transportbänderaustausch	13.10-13.11
Einstellung Transportbänder	13.12
Reparaturberichte	13.13
Brandfall	14.2
Anlagen	15
Elektrische Schaltbilder	16
Pneumatisches Schaltbild	16
Ersatzteile	*am Ende d. Handbuches*

ZUSAMMENFASSUNG VON VERWENDETEN AUSDRÜCKEN, ABKÜRZUNGEN UND ZEICHEN, DIE IN DIESEM HANDBUCH VORKOMMEN

All.	=	Anlage
Dis.	=	Zeichnung
Es.	=	Beispiel
Fig.	=	Abbildung Ersatzteile
Max.	=	Maximum
Min.	=	Minimum
Mod.	=	Modell der Maschine
N.	=	Nummer
N/A	=	Nicht anwendbar (not applicable)
OFF	=	Maschine ausgeschaltet
ON	=	Maschine läuft
OPP	=	Polypropylen orientiert
PLC	=	Programmable Logic Control (frei programmierbare Logiksteuerung)
PP	=	Polypropylen
PTFE	=	Polytetrafluoräthylen
PVC	=	Polyvinylchlorid
Ric.	=	Ersatzteile
SIAT SpA	=	Internationale Gesellschaft f. technische Anwendungen(Aktiengesellschaft)
Tav.	=	illustrierte Tafel

w	=	Breite
h	=	Höhe
l	=	Länge
ol	=	Gesamtlänge
cbh	=	Arbeitstischhöhe

1-EINFÜHRUNG

1.1 FABRIKATIONSNORMEN

Die automatische Kartonverschliessmaschine Mod. SR46-S wurde entwickelt und gebaut, und entspricht den zum Zeitpunkt der Herstellung geltenden gesetzlichen Vorschriften.

BEZUGSDOKUMENTE:

Richtlinie 98/37/EWG Richtlinie zur Angleichung der Rechtsvorschriften der Mitgliedstaaten über die Maschine.
Richtlinie 89/336/EWG Richtlinie zur Angleichung der Rechtsvorschriften der Mitgliedstaaten über die elektromagnetische Verträglichkeit.
Richtlinie 73/23/EWG Richtlinie zur Angleichung der Rechtsvorschriften der Mitgliedstaaten betreffend elektrische Betriebsmittel zur Verwendung innerhalb bestimmter Spannungsgrenzen.
UNI EN 292-1 Sicherheit der Maschine - Basiskonzepte, allgemeine Planungsprinzipien-Terminologie, Grundmethoden.
UNI EN 292-2 Sicherheit der Maschine - Basiskonzepte, allgemeine Planungsprinzipien-technische Spezifikationen und Prinzipien.
UNI EN 294 Sicherheit der Maschine. Sicherheitsabstände, um zu vermeiden dass die oberen Gliedmaßen in Gefahrenzonen gelangen.
UNI EN 349 Sicherheit der Maschine. Mindestabstände, um zu vermeiden, dass Körperteile gequetscht werden.
UNI EN 418 Sicherheit der Maschine. Notstoppausrüstung, Aspekte der Funktion. Planungsprinzipien.
UNI EN 457 Sicherheit der Maschine - Akustische Gefahrensignale- allgemeine Anforderungen, Planung und Tests.
UNI EN 954 Sicherheit der Maschine - Teile der Steuersysteme, die mit der Sicherheit verbunden sind- Allgemeine Planungsprinzipien.
UNI EN 1050 Sicherheit der Maschine - Prinzipien für die Risikoabschätzung.
CEI EN 60204-1 Sicherheit der Maschine- Elektrische Maschinenausrüstungen-Teil 1: Allgemeine Regeln.

1.2 AUSLEGUNG UND GEBRAUCH DER BEDIENUNGSANLEITUNG

1.21 BEDEUTUNG DER BEDIENUNGSANLEITUNG

Dieses Handbuch ist integrierender Bestandteil der Maschine; alle hier enthaltenen Informationen gewährleisten einen sicheren Betrieb und eine perfekte Instandhaltung der Anlage Das Handbuch muss für die gesamte Lebensdauer des Produktes aufbewahrt werden. Man muss sichergehen, daß jegliche Veränderung in den Text aufgenommen wird. Das Handbuch muß jedem Benutzer oder nachfolgendem Besitzer zur Verfügung gestellt werden. Elektrische und pneumatische Schaltbilder sind normalerweise in der Bedienungsanleitung enthalten. Maschinen mit PLC-Steuerung oder elektronischen Komponenten enthalten die Programme und Schaltbilder in den Steuerkonsolen oder werden separat ausgehändigt.

1.2.2 AUFBEWAHRUNG DES HANDBUCHES

Die Bedienungsanleitung sollte an einem trockenen und sauberen Ort, jederzeit zugänglich in der Nähe der Maschine aufbewahrt werden. Es dürfen auf keinen Fall Teile des Handbuches entfernt, zerissen oder abgeändert werden. Das Handbuch sollte so benutzt werden, dass es nicht beschädigt wird. Im Falle von Verlust oder Beschädigung, kann vom zuständigen Technischen Kundendienst eine Ersatzkopie mit Hinweis auf die Dokumentennummer angefordert werden.

1.2.3 KONSULTATION DES HANDBUCHES

Die Bedienungsanleitung besteht aus folgendem:

- Seiten betreffend der Dokumenten- und Maschinenidentifikation;
- nach Argumenten unterteilte Inhaltsangabe;
- Anleitungen und Anmerkungen betreffend der Maschine: Kapitel 2÷14
- Anlagen, Zeichnungen und Schaltbilder:
  Kapitel 15÷16
- Ersatzteile: am Ende des Handbuches

Alle Seiten und Tabellen sind numeriert; die Explosionszeichnungen der Ersatzteile sind mit der Abbildungsnummer identifiziert;
Alle Sicherheitsinformationen und Warnungen betreffend möglicher Gefahrenstellen sind mit dem Symbol: gekennzeichnet.

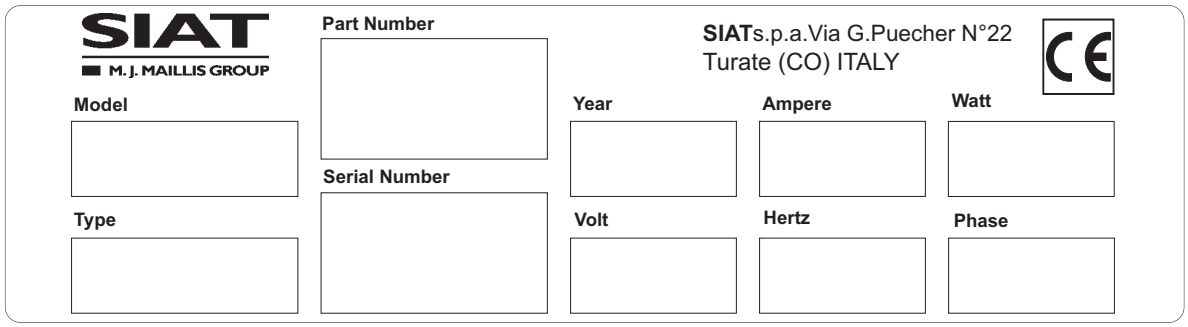
Wichtige Hinweise betreffend Maschinenfunktionen und Betrieb sind mit dem Symbol: ☞ gekennzeichnet.
Dickgedruckte Textstellen werden für technische Spezifikationen oder Funktionen im entsprechenden Kapitel verwendet.

12.4 AKTUALISIERUNG D. BEDIENUNGSANLEITUNG IM FALLE VON MASCHINENÄNDERUNGEN

Jede Maschinenänderung unterliegt der internen, technischen Verfahrensordnung des Herstellers.
Der Käufer erhält mit der Maschine die neueste Ausgabe der Bedienungsanleitung.
Später können zusätzliche Seiten oder Kapitel über Abänderungen nachgeliefert werden. Diese Zusatzblätter müssen vom Käufer der Bedienungsanleitung beigefügt werden.

2-ALLGEMEINE INFORMATIONEN

2.1 ANGABEN ÜBER HERSTELLER UND MASCHINE



2.1 ANGABEN ÜBER TECHNISCHE SERVICESTELLEN UND ERSATZTEILEBESCHAFFUNG

SIAT
M. J. MAILLIS GROUP

Via Puecher, 22
22078 TURATE (CO) - ITALY

Tel. 02-964951
Fax. 02-9682239
E-mail siat@siat.com

AUSSENDIENSTMITARBEITER/ FACHHÄNDLER ODER LOKALER: TECHNISCHER ERSATZTEILDIENST

2.3 GARANTIE

Im Rahmen der weiter unten aufgeführten Darstellungen verpflichtet sich der Lieferant zur Beseitigung sämtlicher im Verlauf der Garantiefrist von sechs (6) Monaten ab Datum der Inbetriebnahme gegebenenfalls auftretenden Konstruktionsmängel, dies jedoch nicht über einen Zeitraum von acht (8) Monaten nach Versanddatum hinaus.Von der Garantie ausdrücklich ausgenommen sind die Teile, bei denen eine normale Abnutzung auftritt, so z.B. Keilriemen, Gummirollen, Dichtungen, Bürsten usw. sowie die elektrische Ausrüstung. Um die Garantieleistungen in Anspruch nehmen zu können, muß der Kunde den Lieferanten unverzüglich über jeden aufgetretenden Mangel mit Angabe der Maschinen-Matrikelnummer informieren.

Der Kunde muß dem Hersteller unverzüglich das defekte Teil für die Reparatur oder den Austausch zukommen lassen.Der Lieferant führt dann die Reparatur in einer angemessenen Zeitspanne aus. Mit der Vornahme der Reparatur oder des Ersatzes erfüllt der Lieferant in vollem Maße seine Garantiepflicht. Falls die Instandsetzung oder der Austausch am Aufstellungsort der Maschine erfolgen muss, gehen die Kosten für die Arbeitskräfte sowie die Reise-und Unterkunftskosten für den Techniker oder Monteur vollkommen zu Lasten des Auftraggebers.

Der Lieferant haftet nicht für Mängel, die auf folgende Ursachen zurückzuführen sind:

- Falsche Verwendung der Maschine
- Mangelnde Wartung
- Eingriffe oder Reparaturen, die vom Auftraggeber durchgeführt worden sind.

Der Lieferant haftet außerdem weder für eventuelle Schäden an Personen oder Sachen, die nicht mit der Maschine, für die Garantie geleistet wird, im Zusammenhang stehen, noch ist er für eine eventuell fehlende Produktion verantwortlich zu machen.

Für Materialien, die nicht vom Lieferanten hergestellt worden sind, wie z.B. elektrische Geräte und Motoren, gewährt dieser dem Auftraggeber die gleichen Garantieleistungen, die ihm selbst seitens des Lieferanten dieses Materials gewährt werden.

Der Lieferant garantiert keine Übereinstimmung der gelieferten Maschinen mit den in einem nicht-EG-Land geltenden gesetzlichen Bestimmungen, insbesondere, was Unfallverhütungsvorschriften und Umweltverschmutzung betrifft.

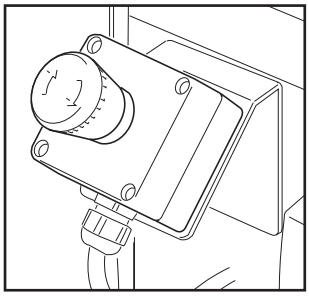
Die Anpassung der Maschinen an die erwähnten Vorschriften geht voll und ganz zu Lasten des Auftraggebers. Dieser übernimmt hierfür die volle Verantwortung und hält den Lieferanten schadlos, indem er ihm jegliche Haftung abnimmt und sich verpflichtet, ihn vor irgendwelchen Forderungen seitens Dritter infolge Nichteinhaltung dieser Vorschriften zu bewahren.

3-SICHERHEIT

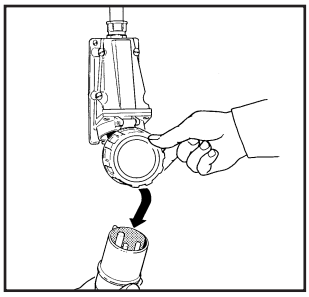
3.1 ALLEGMEINE SICHERHEITSHINWEISE

Vor Inbetriebnahme der Maschine muß die Bedienungsanleitung sorgfältig durchgelesen werden; besondere Aufmerksamkeit verdienen die Kapitel, die mit dem Symbol
gekennzeichnet sind.

Die Maschine ist mit einem Notfall STOP-Schalter ausgestattet, der sich auf der sich auf der Arbeiterseite der Maschine befindet; Die Betätigung des Notfall-STOP- Schalters bewirkt den unmittelbaren Maschinenstop in jeder Phase des Arbeitszyklus, ohne die pneumatische Anlage zu disaktivieren.



Alle Wartungsarbeiten dürfen nur bei unterbrochener Stromzufuhr durchgeführt werden.
Die Bedienungsanleitung sollte gut aufbewahrt werden:



Die darin enthaltenen Informationen dienen dazu, Ihnen einen sicheren Betrieb und eine langjährige Funktionstüchtigkeit der Maschine zu garantieren.

3.2 AUSBILDUNG DES BEDIENUNGSPERSONALES

- Maschinenbediener;
- Verantwortlicher für die mechanische Instandhaltung;
- Verantwortlicher für die elektrische Instandhaltung;
- Techniker des Herstellers

Die Bedienung der Maschine darf nur Personen übertragen werden, die über die in den folgenden Abschnitten definierten Qualifikationen verfügen.
Der Benutzer übernimmt die Verantwortung, die qualifizierten Personen für die unterschiedlichen Aufgaben zu ernennen und sorgt dafür, daß diese die notwendige Ausbildung sowie die korrekte Einweisung mit den in dieser Bedienungsanleitung enthaltenen Vorschriften vermittelt bekommen.

QUALIFIKATION 1

MASCHINENBEDIENER
Der Maschinenbediener ist eine Person, die ausgebildet und qualifiziert ist
Für den Betrieb der Maschine sowohl mittels Benutzung des Generalschalters als auch mittels Benutzung des Notfall-STOP- Schalters,
Einführung und Entnahme des Kartons, Einstellung auf Kartonformat, Klebeband-Rollenwechsel, Inbetriebnahme, Stop und Wiederaufnahme der Produktion.
Bemerkung: Die Fabrik- und Abteilungsleitung muß dafür sorgen, daß der Maschinenbediener sorgfältig in alle Arbeitsschritte eingewiesen wird, bevor er die Maschine in Gang setzt.

QUALIFIKATION 2

VERANTWORTLICHER F. MECHANISCHE INSTANDHALTUNG
Hier handelt es sich um einen qualifizierten Techniker , der jederzeit auch als Maschinenbediener einsetzbar ist. Er sollte weiterhin in der Lage sein, die Maschine auch ohne die installierten Sicherheitsvorrichtungen zu bedienen und Einstellungen an mechanischen Teilen sowie entsprechende Wartungs-und Reparaturarbeiten auszuführen.
Er ist jedoch nicht autorisiert, Eingriffe an unter Strom stehenden Teilen vorzunehmen.

QUALIFIKATION 2a

VERANTWORTLICHER F. ELEKTRISCHE INSTANDHALTUNG
Hier handelt es sich um einen qualifizierten Techniker, der jederzeit auch als Maschinenbediener einsetzbar ist; er sollte weiterhin in der Lage sein, die Maschine auch ohne installierte Sicherheitsvorrichtungen zu betätigen. Er sollte alle Unterhalts- und Reparaturarbeiten an allen unter Strom stehenden elektrischen Komponenten durchführen können; er sollte weiterhin elektrische Prüf-und Testgeräte einsetzen können.

QUALIFIKATION 3

SPEZIALISIERTER TECHNIKER DES HERSTELLERS
Es handelt sich hier um einen qualifizierten Techniker des Herstellers oder seines Vertreters für umfassende Eingriffe an der Maschine- jedoch immer erst nach Absprache mit dem Benutzer..

3.3 VORSCHRIFTEN FÜR DIE SICHERE MASCHINENBEDIENUNG

Die Bedienung der Maschine darf nur Personen übertragen werden, die den im nachfolgenden Abschnitt 3.6 beschriebenen Qualifikationen entsprechen.
Es ist Aufgabe und Verantwortung des Benutzers, die qualifizierten Personen für die verschiedenen Arbeitsabschnitte auszuwählen und dafür zu sorgen, daß diese eine korrekte Einweisung in die in dieser Anleitung enthaltenen Bedienungsvorschriften erhalten.

3.4 BETRIEBSART DER MASCHINE

Aufstellung möglicher Betriebsbedingungen der Kartonverschließmaschine:
- Automatischer Betrieb;
- Betrieb mit reduzierten Schutzvorrichtungen;
- Stop mit Generalschalter;
- Stop mit Notfall-STOP-Schalter;
- Unterbrochene Stromzufuhr;
- Unterbrochene Druckluftzufuhr.

3.5 ANZAHL DER BEDIENUNGSPERSONEN

Die in der nachfolgenden Tabelle beschriebenen Arbeiten sind vom Hersteller analysiert worden; die Anzahl der für die einzelnen Tätigkeiten notwendigen Personen entspricht dem optimalen Wirkungsgrad. Weniger oder mehr Personen könnten die persönliche Sicherheit der betroffenen Personen beeinträchtigen.

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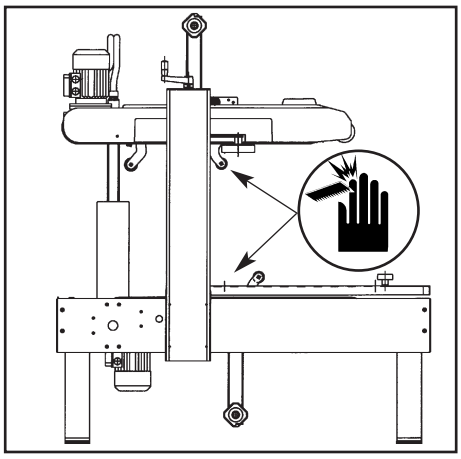
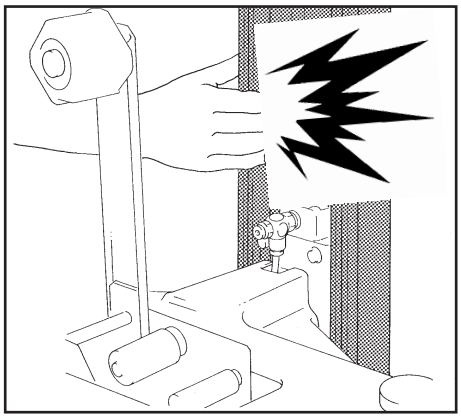
ARBEITSBESCHREIBUNG	BETRIEBSTART	QUALIFIKAT. PERSONEN	ANZAHL
Installation und Vorbereitung für Betrieb.	Betrieb mit reduzierten Schutzvorrichtungen.	**2 und 2a**	2
Klebeband-Rollenwechsel	Gestoppt mittels Notfall-AUS-Schalter (verrieglt).	**1**	1
Austausch des Bandes.	Gestoppt mittels Notfall-AUS-Schalter (verrieglt).	**1**	1
Austausch des Messers.	Gestoppt mittels Unterbrechung d. Strom- und Druckluftzufuhr.	**2**	1
Austausch der Transportbänder.	Gestoppt mittels Unterbrechung d. Strom- und Druckluftzufuhr.	**2**	1
Normale mechanische Wartung.	Gestoppt mittels Unterbrechung d. Strom- und Druckluftzufuhr.	**2**	1
Normale elektrische Wartung.	Gestoppt mittels Unterbrechung d. Strom- und Druckluftzufuhr.	**2a**	1
Aussergewöhnliche mechanische Wartung.	Betrieb mit reduzierten Schutzvorrichtungen.	**3**	1
Aussergewöhnliche elektrische Wartung.	Betrieb mit reduzierten Schutzvorrichtungen.	**3**	1

3.7 RESTGEFAHREN

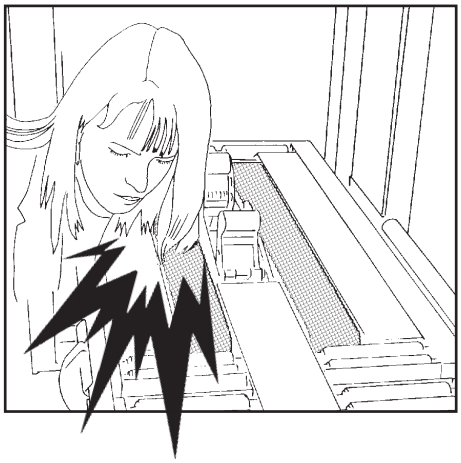
Der Kartonverschließautomat SR4-S wurde gemäß den Richtlinien CE 392 mit den entsprechenden Anpassungen und Sicherheitsvorrichtungen geplant.Diese Sicherheitsvorrichtungen dürfen niemals disaktiviert oder entfernt werden.
Obwohl die Konstrukteure dem Aspekt Sicherheit größte Aufmerksamkeit schenkten, ist es wesentlich, daß der Maschinenbediener und Wartungstechniker vorab auf die nicht ausschließbaren Restgefahren hingewiesen werden.



ACHTUNG! Klebebandtrennmesser
Die Messerschutzvorrichtungen dürfen weder am oberen noch am unteren Klebekopf entfernt werden.



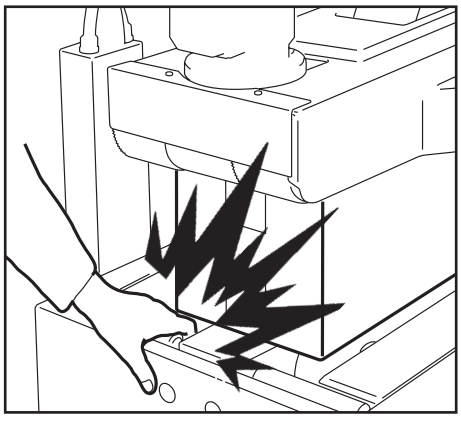
ACHTUIUNG Klebebandtrennmesser
Die Messerschutzvorrichtungen dürfen weder am oberen noch am unteren Klebekopf entfernt werden.



ACHTUNG! Obere und untere zugriemen

.

Lange Haare und lose Kleidungsstücke wie Halstücher oder Krawatten sind gefährlich, obwohl die Transportbänder mit Sicherheitsvorrichtungen versehen sind.



ACHTUNG! Aussparungen am maschinentisch:
Während des Maschinenbetriebes Hände von der Gefahrenzone fernhalten, um Quetschungen zu vermeiden.

ACHTUNG! Obere Antriebsriemen.
Das Antriebsband mit Ihren Händen nie berühren, wenn es läuft.
Quetschengefahr.

3.8 EMPFEHLUNGEN UND UNFALLVERHÜTENDE MASSNAHMEN BZGL. RESTGEFAHREN, DIE NICHT AUSGESCHLOSSEN WERDEN KÖNNEN

Der Maschinenbediener muß immer seine Arbeitsposition einhalten, so wie auf Abschnitt 12.1 angegeben ist; er darf niemals die sich bewegenden Transportbänder anfassen; er darf während des Betriebs kein Teil im Maschineninnern anfassen; er darf nie die Hände in Aussparungen bringen; er muß dafür sorgen, daß die Maschine korrekt versorgt wird, während sich die Hände in der richtigen Position befinden (Abschnitt 4.9) er muß beim Klebeband-Rollenwechsel absolute Vorsicht in der Nähe des Schneidemessers leisten.

3.9 PERSÖNLICHE SCHUTZAUSRÜSTUNG

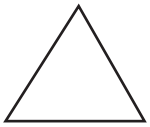
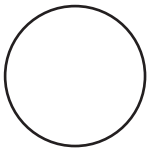
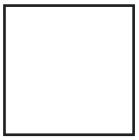
(Schutzbrillen, Arbeitshandschuhe, Schutzhelme, Sicherheitsschuhe, Mundschutz, Lärmschutz usw.) nicht erforderlich, falls nicht ausdrücklich vom Benutzer empfohlen.

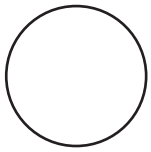
3.10 VERBOTE BETREFFEND NICHT ERLAUBTEN, ODER NICHT KORREKTEN, JEDOCH LOGISCHERWEISE VORAUSSEHBAREN VERHALTENSWEISEN

- Niemals versuchen, einen von der Maschine übernommenen Karton aufzuhalten. in diesem Fall i m m e r den Notfall-STOP-Knopf drücken.
- Niemals die Maschine in Betrieb setzen, wenn die Sicherheitsvorrichtungen entfernt worden sind.
- Schutzvorrichtungen dürfen auf keinen Fall entfernt werden.
- Nur autorisiertes Personal ist befugt, Einstellungen, Reparaturen und Wartungsarbeiten, die für den Betrieb der Maschine notwendig sind, mit reduzierten Schutzvorrichtungen durchzuführen.
  Während dieser Arbeiten ist der Zugang zur der Maschine nur für qualifiziertes Personal zugelassen.
  Am Ende dieser Vorgänge muß unverzüglich der Zustand der Maschine mit allen aktiven Schutzvorrichtungen wiederhergestellt werden.

- Reinigungs- und Wartungsarbeiten dürfen nur bei unterbrochener Strom- und Druckluftzufuhr vorgenommen werden.
- die Maschine darf nur mit trockenen Lappen oder verdünnten Reinigungsmitteln gereinigt werden. Es dürfen auf keinen Fall Lösungsmittel oder Benzin verwendet werden.
- Es dürfen keinerlei Änderungen an der Maschine oder an Teilen vorgenommen werden. Die SIAT übernimmt keinerlei Haftung bei eventuellen Konsequenzen.
- Es wird empfohlen, Genehmigungen f.eventuelle Änderungen bei der SIAT S.p.A. einzuholen.
- Die Maschinenaufstellung muß gemäß den Vorschriften betreffend der Inbetriebnahme der Maschine, die in diesem Handbuch enthalten sind, befolgt werden. Die SIAT S.p.A. übernimmt keinerlei Haftung für Probleme, die durch eine nicht ordnungsgemäße, abweichende Installationsart erursacht werden.

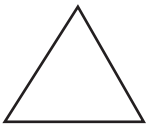
3.11 TABLE OF WARNINGS, LABELS, PLATES AND DRAWINGS TO BE FOUND ON THE MACHINE ZUSAMMENFASSUNG DER WARN/HINWEISSCHILDER UND ZEICHNUNGEN AUF DER MASCHINE

	LEGENDE SUMBOLE	LEGENDE FARBEN
	GEFÄHRLICHE TEILE IN BEWEGUNG	FARBE GELB
	VERPFLICHTUNG/VERBOTE	FARBE ROT
	STEUERUNGEN UND INFORMATIONEN	FARBE BLAU

a 

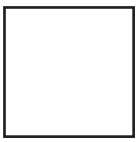
Zeigt an, daß der Endanschlag, der die Höhe des oberen Kopfes reguliert, nicht in Abwesenheit von Druckluft entrieget werden darf.

Eikettennummer: 3.0.010604.96/A

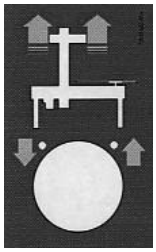
b 

Warnt den Bediener vor dem Anfassen des Hebels, der das Ventil für das Heben des oberen Kopfes antreibt.

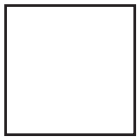
Etikettennummer: 3.0.01029.96A

c 

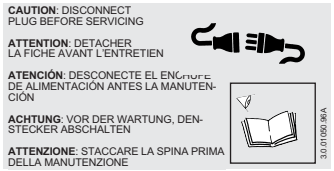
Zeigt den Schalter HEBEN/SENKEN des Kopfes an, der dann das Herausnehmen des unteren Klebekopfes erleichtert.



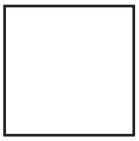
Etikettennummer: 3.0.01047.96A

d 

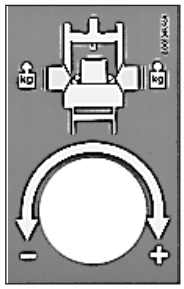
Weist darauf hin, daß es unbedingt notwendig ist, vor Beginn jeglicher Wartungsarbeit den Stecker aus der Steckdose zu ziehen.


CAUTION: DISCONNECT PLUG BEFORE SERVICING
ATTENTION: DETACHER LA FICHE AVANT L'ENTRETIEN
ATENCIÓN: DESCONECTE EL ENCHUFE DE ALIMENTACIÓN ANTES LA MANUTENCIÓN
ACHTUNG: VOR DER WARTUNG, DEN STECKER ABSCHALTEN
ATTENZIONE: STACCARE LA SPINA PRIMA DELLA MANUTENZIONE
3.0.01050.96A

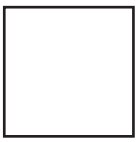
Etikettennummer: 3.0.01050.96A

e 

Zeigt den Knopf für die Druckeinstellung der seitlichen Führungsschienen auf dem Karton an.

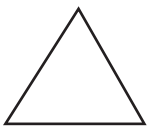


Etikettennummer: 3.0.01049.96A

f 

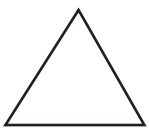
Zeigt den Knopf für die Gewichtseinstellung des Kopfes auf dem Karton an.

Etikettennummer: 3.0.01048.96A

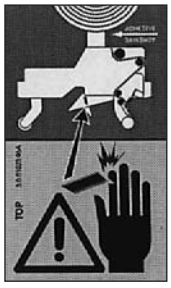
g 

Weist auf die Gefahr des Messers des Klebekopfes hin.

Etikettennummer: 3.0.01028.96A

h 

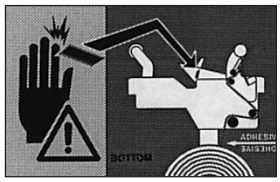
Zeigt den Bandverlauf der oberen Bandeinheit, sowie die Gefahr durch das Messer an.



Etikettennummer: 3.0.01023.96A

i

Zeigt den Bandverlauf der unteren Bandeinheit, sowie die Gefahr durch das Messer an.



Etikettennummer: 3.0.01024.96A

l

Zeigt die Bewegungsrichtung der Transportbänder an.

Etikettennummer: 3.0.01040.96A

m

Zeigt an, daß sich Luft im Kreislauf befindet (rote sichtbare Anzeige).

Etikettennummer: 3.0.01035.96A

n

Weist den Bediener darauf hin, den Hebel, der das Ventil zum Öffnen/Schließen der seitlichen Schachtelführungen antreibt, nicht zu berühren.

Etikettennummer: 3.0.01027.96A

o

Weist den Bediener darauf hin, daß er aufpassen muß, nichts in die Aushöhlungen der seitlichen Schachtelführungen zu bringen.

Etikettennummer: 3.0.01036.96A

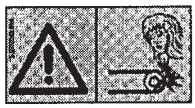
p

Weist den Maschinenbediener darauf hin, daß er nicht die Säulen , in deren Innenraum sich der Hebezylinder befindet, anfassen soll.

Etikettennummer: 3.0.01041.96A

q

Weist auf die Gefahr der sich bewegenden oberen Transportbänder hin.



Etikettennummer: 3.0.01030.96A

r

Weist auf die Gefahr der sich bewegenden unteren Transportbänder hin.

Etikettennummer: 3.0.01031.96A

s

Zeigt die Steuerungen AN/AUS an und weist darauf hin, daß im Inneren der Schachtel des magnetothermischen Schalters Strom vorhanden ist.

Etikettennummer: 3.0.01090.96A

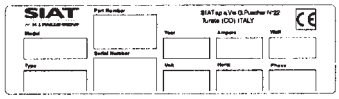
t

Zeigt den Punkt an, an dem der Schutzdraht mit dem Maschinenkörper verbunden ist (Erde).

Etikettennummer: 3.0.01039.96A

u

Zeigt die Modellidentifikationsdaten, die Matrikelnummer und den Hersteller der Maschine an.



Label code: SBC0000629

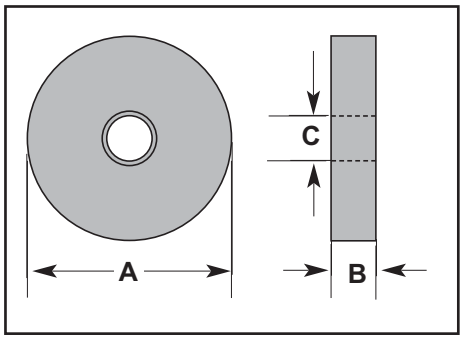
4-EINLEITENDE MASCHINENINFORMATIONEN

4.1 ALLGEMEINE BESCHREIBUNG DER MASCHINE

Kartonverschließmaschine mit oberem und unterem Förderbandantrieb für das Verschließen von Schachteln mit verschiedenen Formaten.

4.2 TECHNISCHE DATEN

- Durchschnittl. Produktion = 650 Kartons/Std
- Stromanschluss standard = 230/400V 50Hz 3Ph
- N. 2 Motoren (HP 0,18) kW 0,12
- Klebeband K12, Klebebandbreite 75 mm
- Gewicht = 165 kg
- Fördergeschwindigkeit = 22 m/minuto
- Druckluftverbrauch max 6 Bar



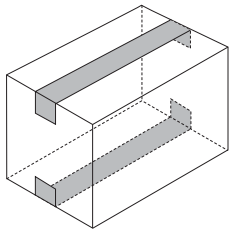
A = 410 mm max
B = 75 mm
C = 76 mm

4.3 KLEBEBANDMASSE

Geeignete Klebebänder:
PVC
OPP
Selbstklebepapier

4.4 BEABSICHTIGTER GEBRAUCH

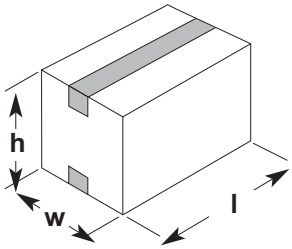
Verschluß mit Selbstklebeband der Kartons mit den Abmessungen (in Millimeter), die im Abschnitt 4.5. angegeben sind, d.h. mittels gleichzeitiger Anwendung von 2 Selbstklebestreifen (einer auf der oberen und einer auf der unteren Seite des Karton).
Die Maschine mit einer elektrischen Standardausruestung darf nicht in einer explosionsgefährdeten Umgebung eingesetzt werden, wo explosionsgeschützte Bauteile oder luftangetriebene Motoren vorgeschrieben sind.

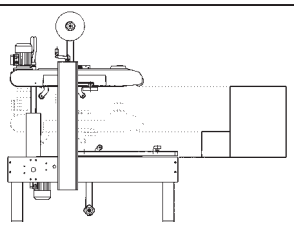


4.5 KARTON-FORMATE

Der Kartonverschließautomat SR4-S kann automatisch Schachteln verschließen, deren Abmessungen sich im Bereich der unten aufgeführten Größen bewegen (Teil 1).

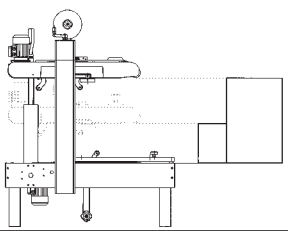
Für das Verschließen von Schachteln mit Abmessungen bis zu 750 mm Höhe ist es möglich, die Position der festen Säulen zu erhöhen, so wie in der unten angegebenen Zeichnung gezeigt wird (Teil 2).





1 SAUELEN IN UNTERE POSITION

KARTONFORMAT		MIN	MAX
	L	**150**	
	W	**170**	**650**
	H	**130**	**750**



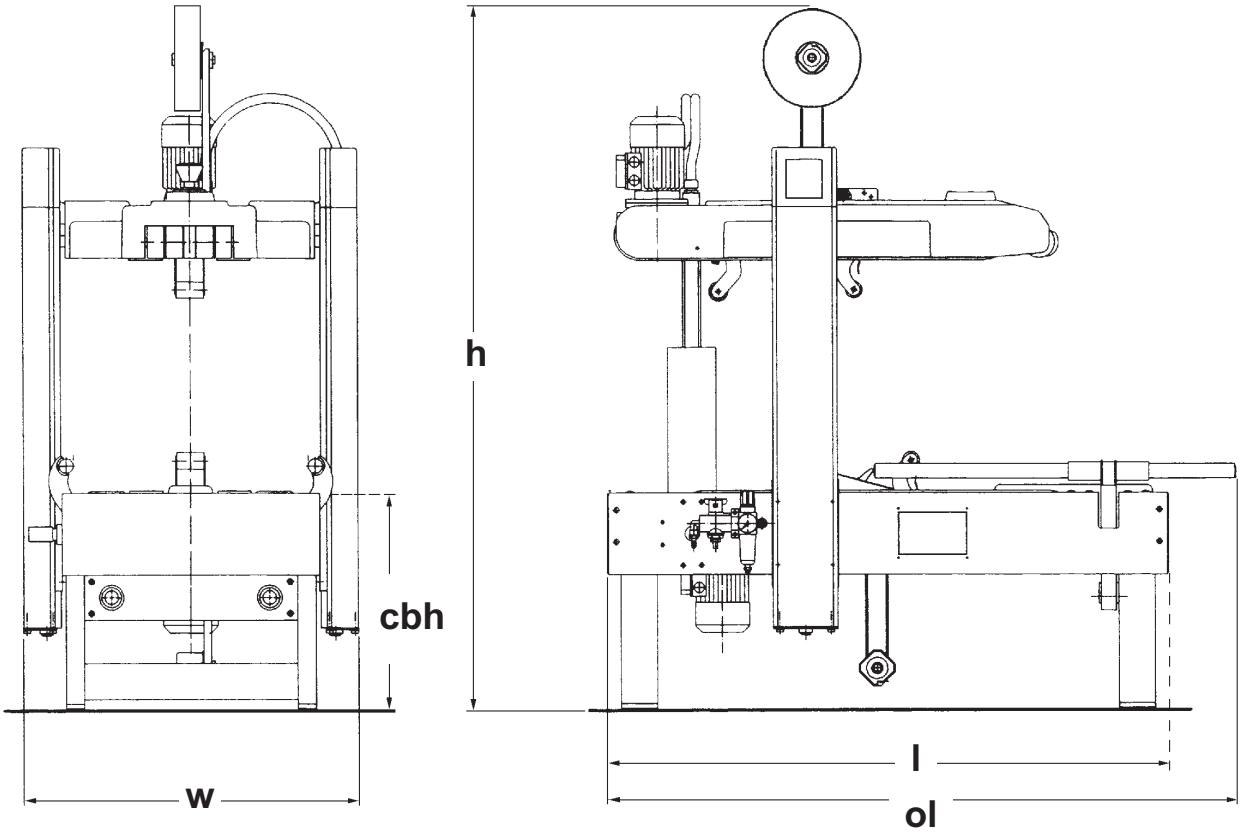
2 SAUELEN IN OBERER POSITION

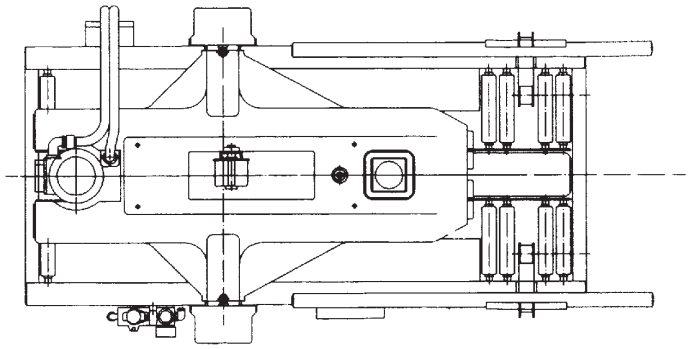
KARTONFORMAT		MIN	MAX
	L	**150**	
	W	**170**	**650**
	H	**340**	**930**

Bemerkung

- Die Kartonlänge (L) bezieht sich auf die Abmessungen , gemessen in Klebebandverschluß-Richtung.
- Die Kartons müssen ein Verhältnis (Länge/Höhe) haben, das größer als 0,5 ist. Bei Kartons, bei denen das Verhältnis niedriger ist, muß man einen Test durchführen, um die perfekte Funktionalität, die von verschiedenen Faktoren wie dem Gewicht und der Starre abhängt, zu gewährleisten.
- In einigen Fällen ist es möglich, daß der Hersteller spezielle Änderungen an der Maschine SR4 vornimmt, die dem Verschließen von Kartons mit kleineren oder größeren Formaten dienen und von den gängigen Formaten abweichen. Für weitere Informationen muß man sich mit dem technischen Kundendienst SIAT in Verbindung setzen.

4.6 MASCHINENABMESSUNGEN



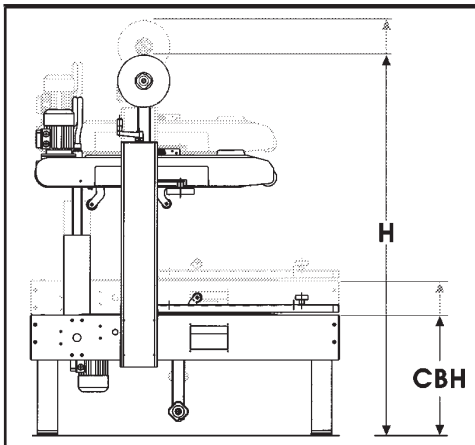


MASCHINENABMESSUNGEN

l = Laenge 1240 mm
w = Breit 940 mm
h = Höhe1275÷2025 mm
ol = Gesamtlänge, einschl. der Zentrierstangen: 1390 mm
cbh = Fördertischhöhe: siehe abschnitt 4.7

4.7 FÖRDERTISCHHÖHE

Die Kartonverschließmaschine verfügt über einen breiten Einstellungsspielraum für das Kartonförderband. Es können mit speziellem Zubehör AS77 (Räder) und AS80 (Füße) verschiedene Kombinationen erreicht werden; hierfür sollte man sich auf die Tabelle der nachfolgenden Seite beziehen.



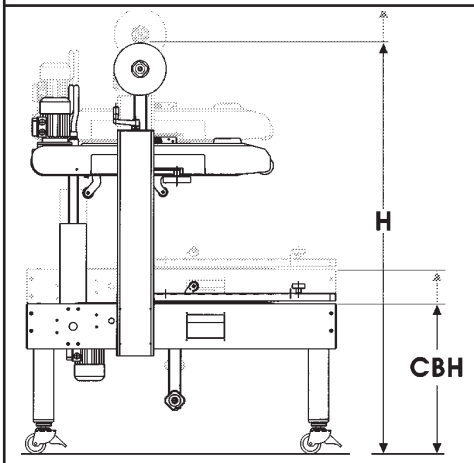
A STANDARDBEINE

FÖRDERTISCHHÖHE

	MIN	MAX
CBH	**485**	**825**

ALLGEMEINE ABMESSUNGEN

	MIN	MAX
H	**1275**	**2025**
L	**1240**	**1240**
W	**940**	**940**



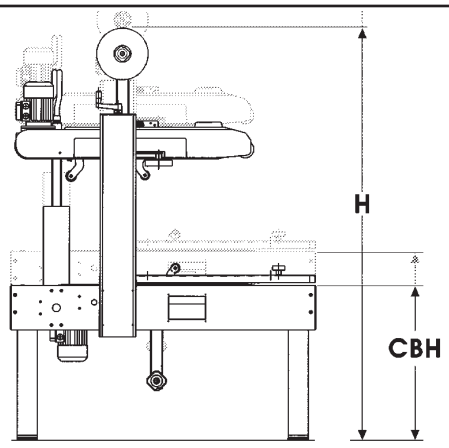
B MIT RAEDERN AS77 (ZUSATTZUBEHOER)

FÖRDERTISCHHÖHE

	MIN	MAX
CBH	**585**	**925**

ALLGEMEINE ABMESSUNGEN

	MIN	MAX
H	**1375**	**2125**
L	**1240**	**1240**
W	**940**	**940**



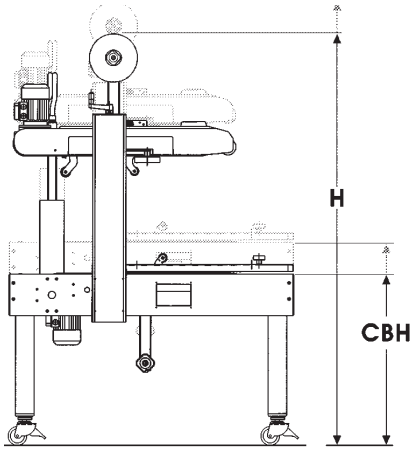
C MIT BEINEN AS80 (ZUSATTZUBEHOER)

FÖRDERTISCHHÖHE

	MIN	MAX
CBH	**645**	**1135**

ALLGEMEINE ABMESSUNGEN

	MIN	MAX
H	**1435**	**2335**
L	**1240**	**1240**
W	**940**	**940**



D MIT BEINEN AS80 UND RAEDERN AS77 (ZUSATTZUBEHOER)

FÖRDERTISCHHÖHE

	MIN	MAX
CBH	**745**	**1235**

ALLGEMEINE ABMESSUNGEN

	MIN	MAX
H	**1535**	**2435**
L	**1240**	**1240**
W	**940**	**940**

4.8 HAUPTKOMPONENTEN DER MASCHINE

Die Maschine besteht aus:

N. 1 Rahmen
N. 4 Einstellbaren Beinen
N. 2 Säulen
N. 2 Klebeeinheit
N. 1 Oberer Zylinderkopf
N. 1 Oberer Transportantrieb
N. 1 Unterer Transportantrieb
N. 2 Elektrische Motoren
N. 1 Taste STOP NOTFALL
N. 1 Hauptschalter EIN/AUS

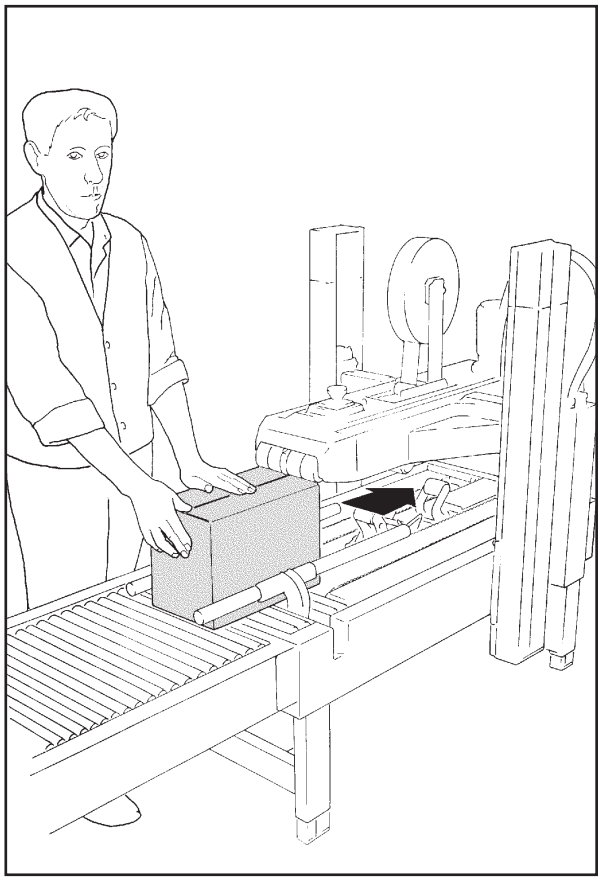
Für die technischen Eigenschaften der elektrischen Komponenten , bitte **Kapitel 15** - Anlagen überprüfen.

4.9 ARBEITSABLAUF

Nachdem der Karton aufgefüllt wurde, müssen die oberen Klappen geschlossen werden und die Schachtel muß gegen den Hebel gestoßen werden, der das Heben des oberen Kopfes steuert. Den Karton in die Maschine einführen, bis er auf den Förderbändern liegt. Der Karton wird somit von den Bändern gefördert, wenn die obere Gruppe wieder heruntergekommen ist.

Die Hände müssen so gehalten werden, wie auf Tafel gezeigt wird.

Der Karton wird dann automatisch auf der oberen und auch auf der unteren Seite mit Klebeband verschlossen und auf das Ausgangsförderband geschoben.



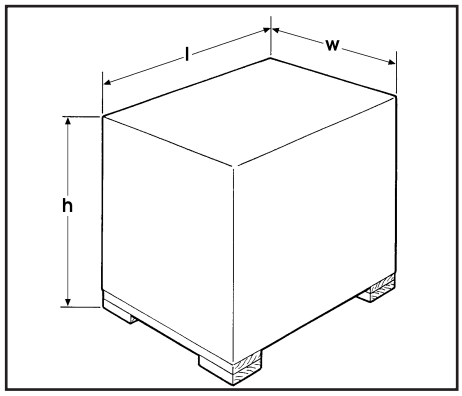
4.10 MESSUNG DES GERÄUSCHPEGELS

Gemessener Schalldruck bei einer Maschinenentfernung von 1 m mit eingesetztem Klebeband: 73 dB.
Schalldruck bei einer Höhe von 1,6 m von der Maschine entfernt mit eingesetztem Klebeband: 73 dB.
Die Messungen wurden mit einem Instrument Typ SPYRI-MICROPHON durchgeführt.

5-TRANSPORT-HANDHABUNG UND LAGERUNG

5.1 HANDHABUNG UND TRANSPORT DER VERPACKTEN MASCHINE

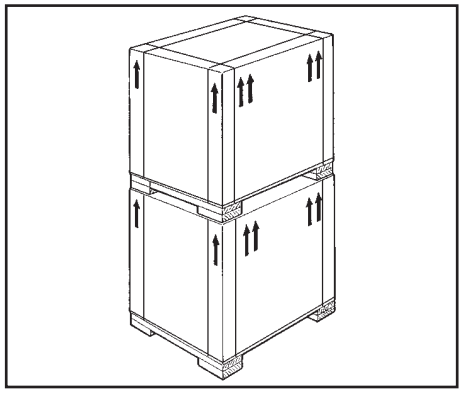
Die Maschine ist mittels 4 durchgehenden Schrauben an der Pallette gesichert und kann mit einem Gabelstapler oder Hubwagen angehoben werden. Die Verpackung eignet sich für den Land- und Lufttransport. Uberseeverpackungen auf Anfragen.



Abmessungen der Verpackung

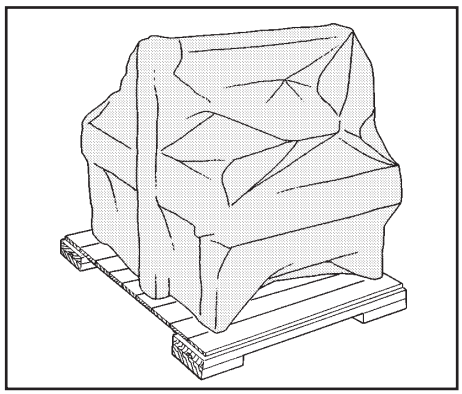
l = Länge 1400 mm
w = Breite 1000 mm
h = Höhe 1300 mm
Gewicht kg. 210

Bei Transport und während der Lagerung koennen max. 2 Maschinen aufeinandergestapelt werden.



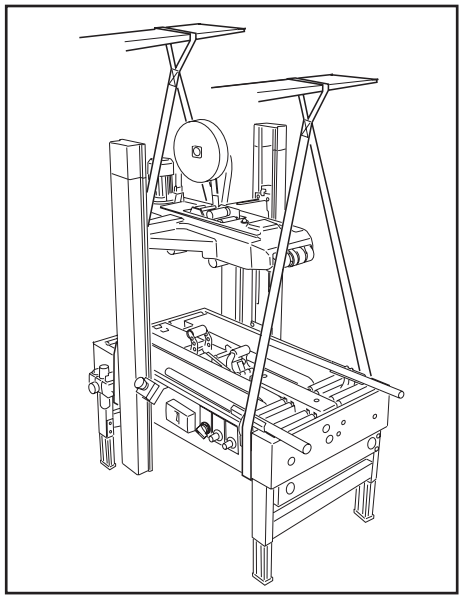
5.2 ÜBERSEE- VERPACKUNG

(Sonderausführung)
Bei Überseetransporten wird die Maschine in einen Sack gepackt, der aus Aluminium/Polyester/Polyten mit wasserentziehenden Salzen besteht.



5.3 HANDHABUNG UND TRANSPORT VON UNVERPACKTER MASCHINE

Die unverpackte Maschine darf nicht transportiert werden, außer auf sehr kurzen Entfernungen und im Innern der Abteilungen. Der Transport der unverpackten Maschine kann Schäden und Unfälle verursachen. Sollte die Maschine versetzt werden, muß sie mit Heberiemen umwickelt und mit einem Gabelstapler oder mit einem Kran angehoben werden.



ABMESSUNGEN DER MASCHINE
Länge 1240 mm
Breite 940 mm
Mind.Höhe1275; max.2025 mm
Gewicht kg 165

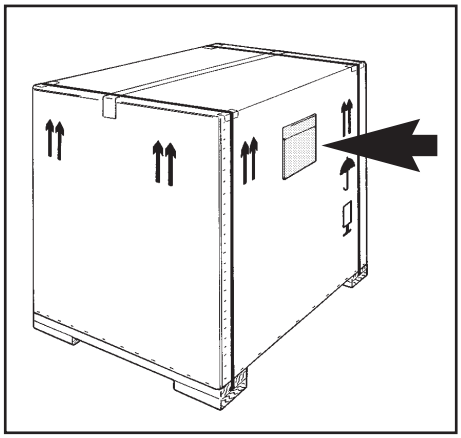
5.4 LAGERUNG DER VERPACKTEN ODER AUSGEPACKTEN MASCHINE

Falls die Maschine für längere Zeit nicht benutzt wird, sind die folgenden Maßnahmen zu beachten:

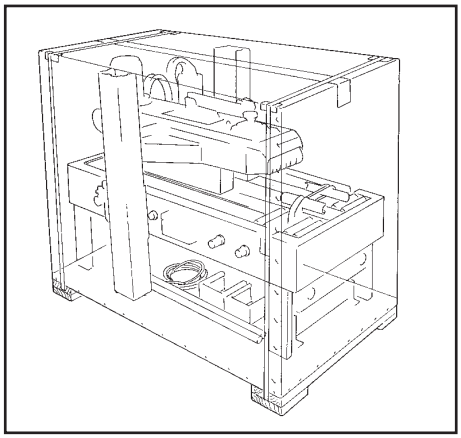
- Maschine an einem trockenen und sauberen Ort lagern;
- die ausgepackte Maschine muß gegen Staub geschützt werden und es dür fen keinerlei Gegenstände auf der Maschine deponiert werden;
- Bei Maschinen, die noch original verpackt sind, können maximal 2 aufeinandergestellt werden.

6-AUSPACKEN

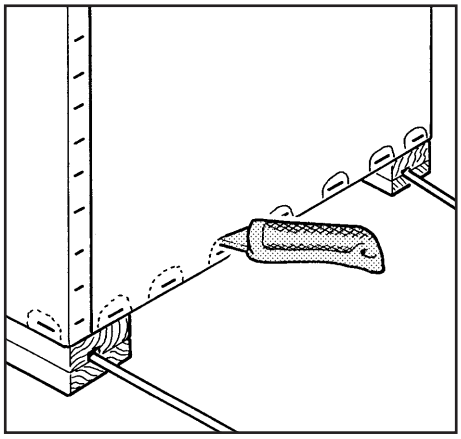
6.1 Der am Versandkarton der Maschine angebrachte Umschlag enthält die Auspackanleitung.



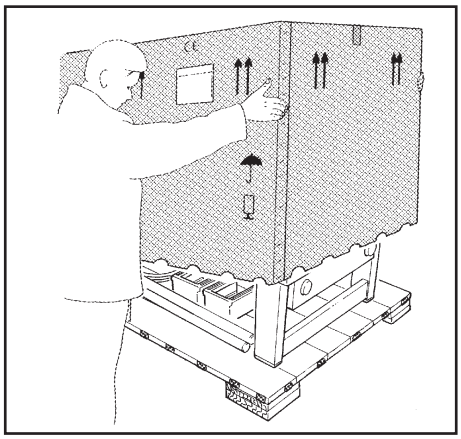
Maschinenposition im Innern der Verpackung.



Polypropylenreifung durchschneiden.
Mit dem Cutter die Kartonseite öffnen, die mit den Heftklammern befestigt worden ist; diese Arbeit entlang dem unteren Kartonrand durchführen (oder es sollten die Metallklemmen mit einem geeigneten Werkzeug, falls vorhanden, entfernt werden).

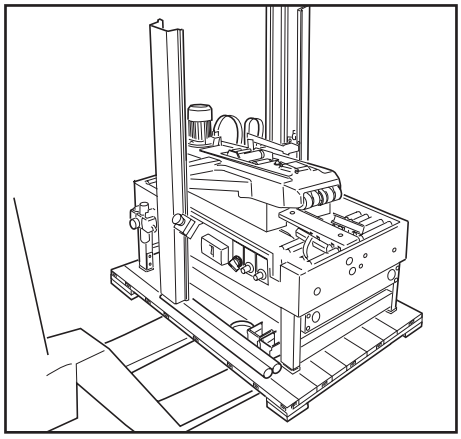


Nachdem der Karton aufgeschnitten worden ist (oder nach dem Entfernen der Metallklammern), muß der Verpackungskarton vollständig angehoben werden, um so die Maschine frei zu bekommen. (2 Personen)

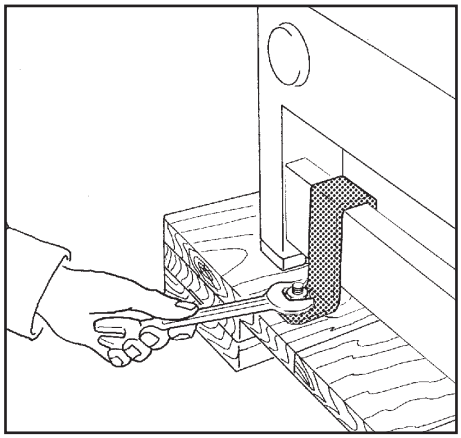


6-AUSPACKEN

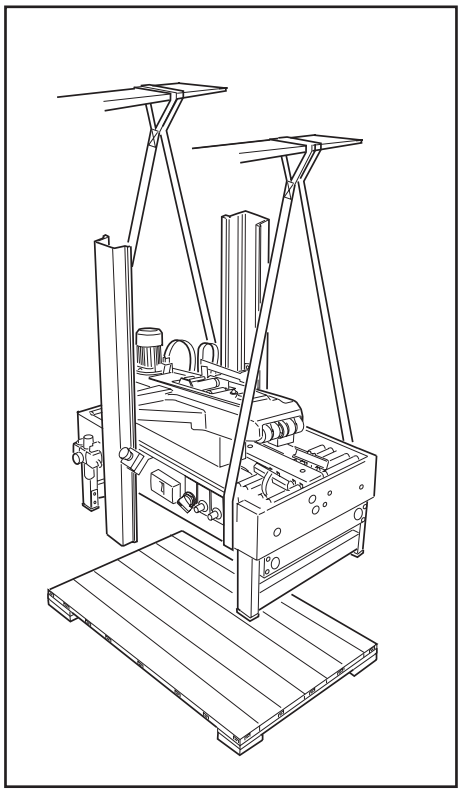
Maschine mit Gabelstapler oder mit Handgabelhubwagen in die Arbeitsposition transportieren.
(Maschinengewicht + Palette = kg. 185)



Muttern lösen und die Befestigungswinkel, die die Maschine an der Palette befestigen, mit dem mitgelieferten Schraubenzieher entfernen.



Die Maschine, wie im Bild gezeigt wird, anheben (Maschinengewicht 165 kg) und die Holzpalette entfernen.



6.2 ENTSORGUNG DES VERPACKUNGSMATERIALS

Die Verpackung der Maschine vom Mod. SR46-S besteht aus folgenden Teilen:
- Holzpalette;
- Versandkarton;
- Befestigungswinkel aus Stahl;
- PU-Schaum-Schutzteile;
- PP-Umreifungsband
- wasserentziehendes Salz (nur für Übersee)
- Sack aus Polyester/Aluminium/Polyäthylen ((Nur für Übersee).

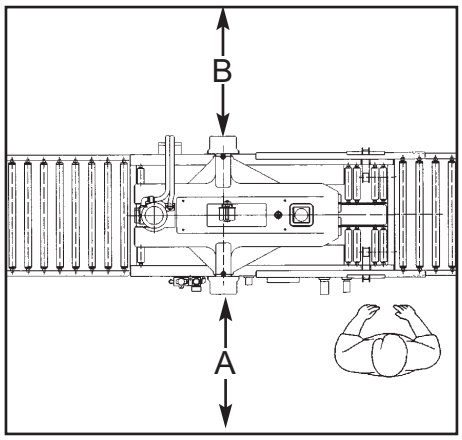
Die Entsorgung dieser Materialien hängt von den entsprechenden Vorschriften in den einzelnen Ländern Ab.

7-MASCHINENAUFSTELLUNG

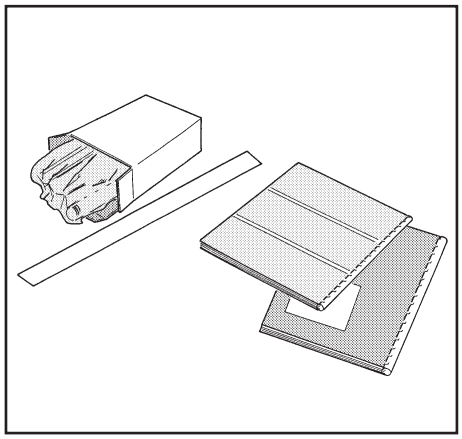
7.0 SICHERHEIT
(Bitte mit großer Aufmerksamkeit Kapitel 3 lesen).

7.1 UMWELTBEDINGUNGEN
-Min.Temperatur = 5° C; -Max.Temperatur = 40° C
-Min.Luftfeuchtigkeit 30%; -Max.Luftfeuchtigkeit 80%
-Staubfreie Umgebung

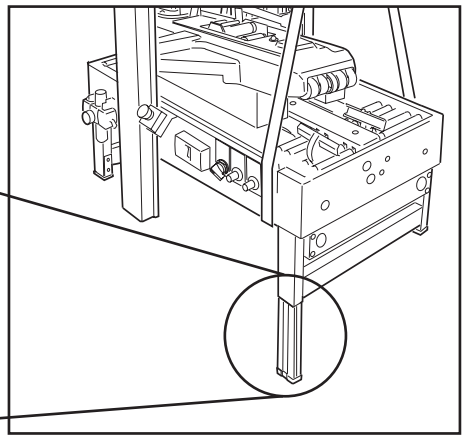
7.2 RAUMBEDARF FR BETRIEBS-UND WARTUNGSARBEITEN
Mindestabstand von der Wand:
A = **1000** mm; **B** = **700** mm
Mindesthöhe = **2500** mm

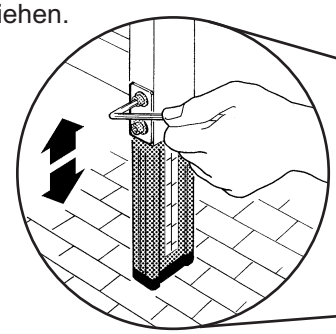


7.3 MITGELIEFERTE ERSATZTEILE UND WERKZEUGSATZ
Die genaue Beschreibung dieser Werkzeuge befindet sich im Abschnitt 13.1.

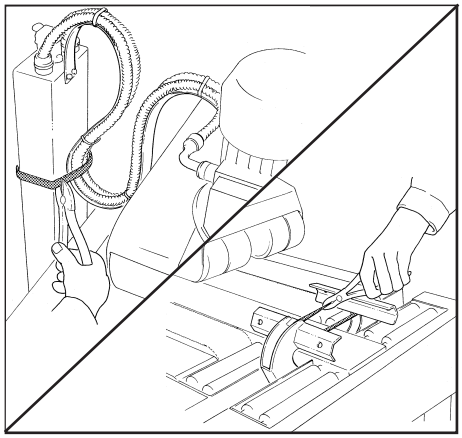


7.4 AUFSTELLUNG
Die Maschine, wie in Tafel gezeigt wird, anheben.
Die gezeigten Schrauben lösen und die Beine herausziehen, indem dabei die Höhenskala beachtet wird. Dann die Schrauben auf der gewuenschten Höhe wieder festanziehen.



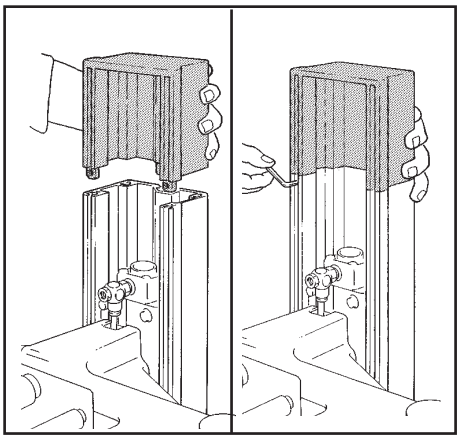


7.5 ENTFERNUNG DER BLOCKIERUNGEN
Sowohl die Schelle, die den Gurt an die Führung mit den Vorsorgungskabeln f. Motor und Notfall-Schalter blockiert, als auch die Schelle, die den Hebel des Zentrierwinkels blockiert, durchschneiden.



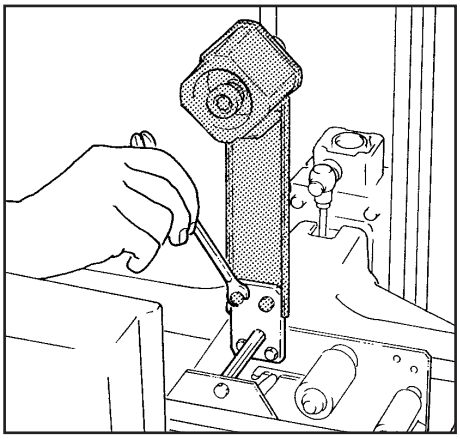
7.6 POSITIONIERUNG DES SÄULENSCHUTZES

Man muß die Säulensicherheitsverkleidungen wieder montieren, so wie es auf Tafel gezeigt wird.



7.7 POSITIONIERUNG DES ROLLENHALTERS DES OBEREN KLEBEBANDES

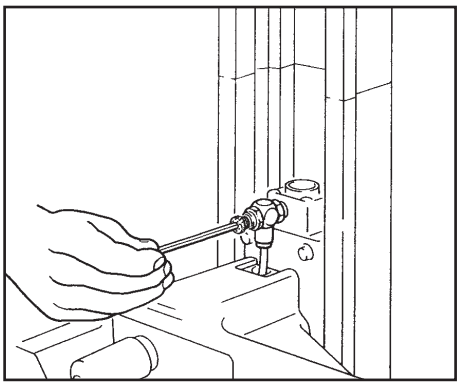
Die Schrauben, die den Klebebandhalter an der Maschine befestigen, lösen und ihn, wie es auf Tafel gezeigt wird, in Position bringen; anschließend muß der Klebebandhalter mit den Schrauben, die man vorher entfernt hatte, blockiert werden.

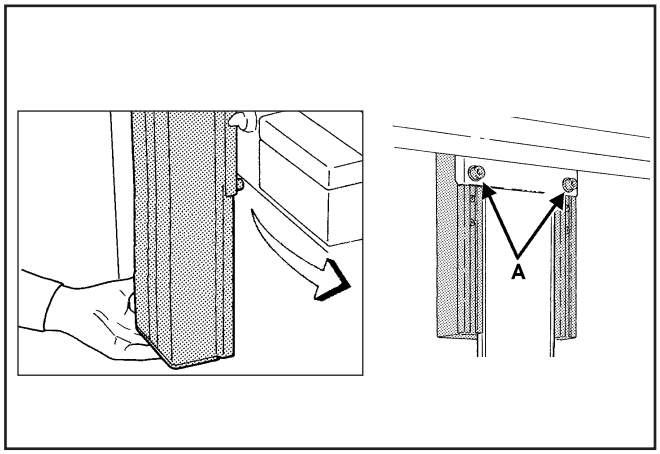


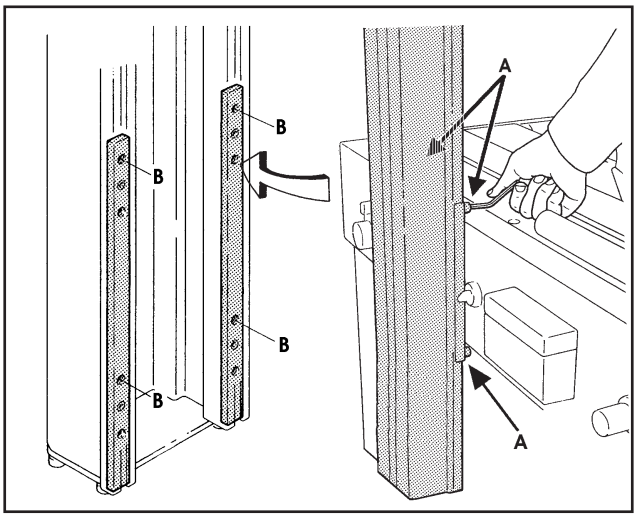
7.8 POSITIONIERUNG DER SÄULEN

Deckel des pneumatischen Zylinders lockern.

Mit einer Hand die Säule halten und die beiden Schrauben entfernen (**A**).
Die Säule noch oben drücken bis sie sich in der Position der beiden Löcher befindet (**B**). Dann die Säule mit den anderen beiden Schrauben, die in die Ersatzteile geschraubt sind, befestigen
(vier Schrauben pro Säule).

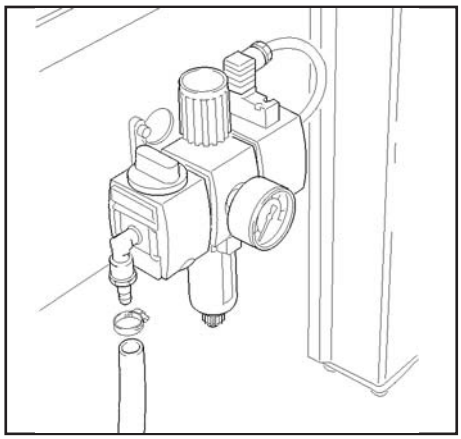




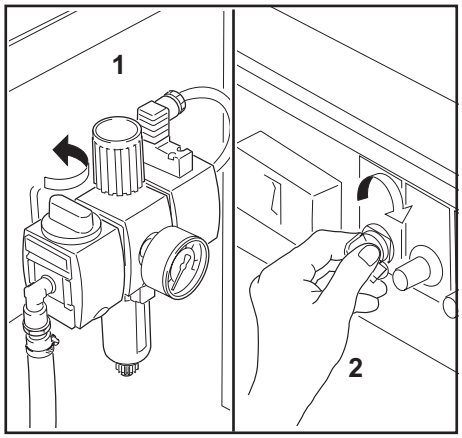


7.9 PNEUMATISCHER ANSCHLUSS

Man muß einen 8 mm-Schlauch an das Anschlußstück anschließen und direkt mit einer Schelle, die mitgeliefert wird, befestigen.

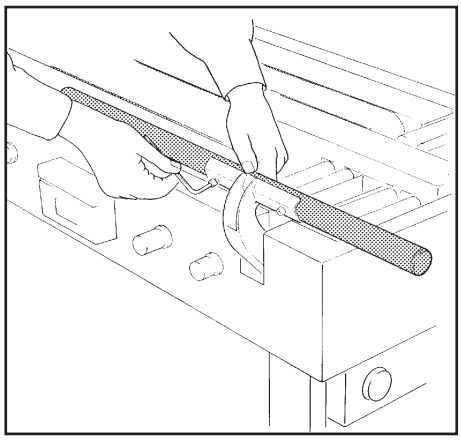


Man muß jetzt die pneumatische Anlage aktivieren, indem man auf den Handgriff **1** einwirkt, und den obereren Zylinderkopf anheben, indem man auf den Wahlschalter einwirkt (**2**).
Anschließend die Styroporblöcke, die für den Transport benutzt worden sind , entfernen.



7.10 POSITIONIERUNG DER SEITLICHEN FÜHRUNGEN

Die Kartonführungsschienen auf den Zentrierwinkelhebel montieren, so wie auf Tafel dargestellt wird.



1.11 ELEKTRISCHE VORABKONTROLLEN

Bevor die Maschine ans Stromnetz angeschlossen werden kann, müssen folgende Kontrollen durchgeführt werden:

7.11.1 Überprüfen, daß das Netz mit einer Fehlerstromschutzschaltung versehen ist und daß die Netzwerte mit den Angaben des Typenschildes der Maschine übereinstimmen.

7.11.2 Es unterliegt der Verantwortung des Benutzers, daß der Maschinenanschluß gemäß den geltenden lokalen Gesetzen und/oder Anschlussvorschriften durchgeführt wird.

7.11.3 Der Elektrohauptschalter hat einen max. Unterbrechungswert von 6 kA und einen Kurzschlußauslöser, der auf 120 A voreingestellt ist.
Der Benutzer ist verantwortlich für die Prüfung der Fehlerstromschaltung vor Ort und muß auch sicherstellen, daß die Intensität des Stroms an den Klemmen des Hauptschalters mit der Anlage selbst kompatibel ist.

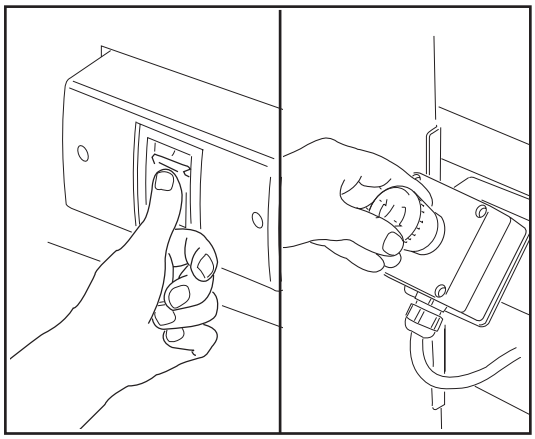
7.12 STROMANSCHLUSS UND ENTSPRECHENDE KONTROLLEN

Installierte Leistung = kW 0,240
Schaltleistung des Haupschalters = 6 kA (230/400V)
Was die technischen Eigenschaften des Hauptschalters betrifft, siehe **Kapitel 15** - **Anlagen**.

- Notfall-STOP-Taste drücken.
- der magnetisch-thermische Hauptschalter steht normalerweise auf OFF.
- Einen Stecker, der den geltenden Landesnormen/-gesetzen entspricht, mit dem Kabel, das mit der Ma schine mitgeliefert wird, verbinden.

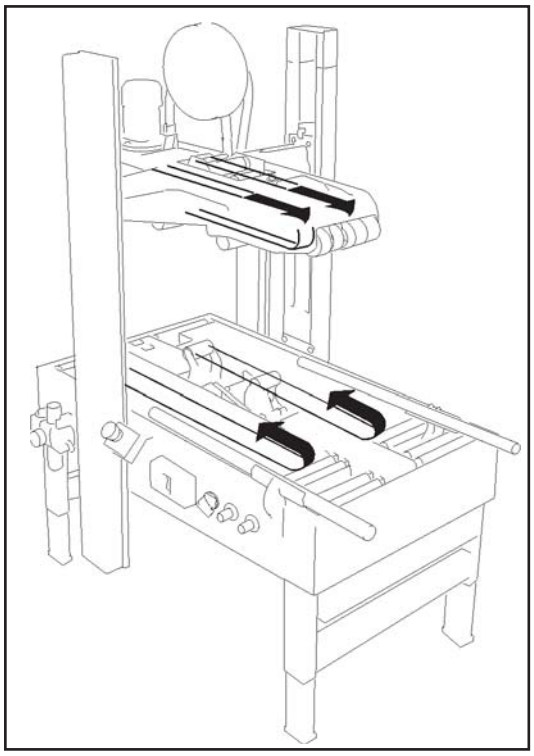
7.13 PHASEN-ANSCHLUSSKONTROLLE (BEI DREIPHASIGER SPEISUNG)

Korrekte Phasenanschlüsse wie folgt überprüfen:



- eventuelle Werkzeuge , die sich auf der Maschine befinden, entfernen.
- Notausschalter durch Drehen im Uhrzeigersinn entriegeln.
- “EIN”-Schalttaste am Hauptschalter drücken
- Vor Inbetriebnahme korrekte Rotationsrichtung der Antrieb sbänder kontrollieren.
- Falls die Bänder in der falschen Richtung rotieren, müssen die zwei Phasen des Kabelsteckers umgepolt werden.

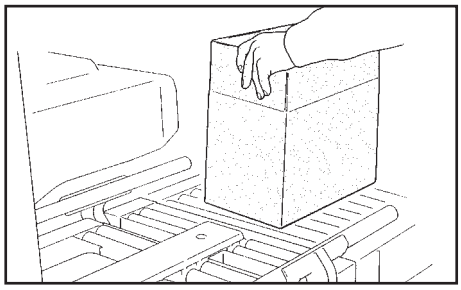
Korrekte Rotationsrichtung der Antriebsbänder.



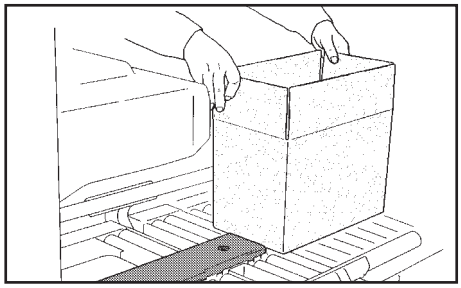
8-MASCHINENFUNKTION

8.1 BESCHREIBUNG DES BETRIEBES

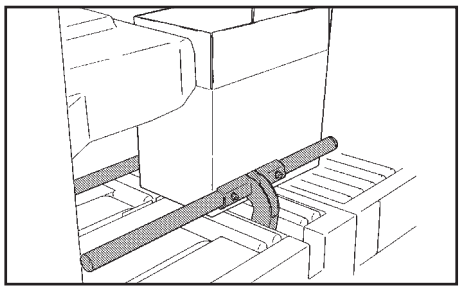
Manuell die vier Unterseiten des Kartons knicken.
Den Karton mit den geknickten Unterseiten auf das Förderband auflegen.



Den Karton mit beiden Händen festhalten und laufenlassen, bis er das Hebelventil drückt. Auf diese Weise nähern sich die seitlichen Führungen dem Karton.

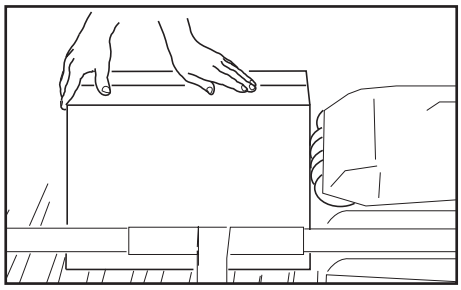


Die seitlichen Führungen blockieren den Karton auf dem Zentriergerät und erlauben so ein Auffüllen des Kartons, ohne denselben mit den Händen festhalten zu müssen.



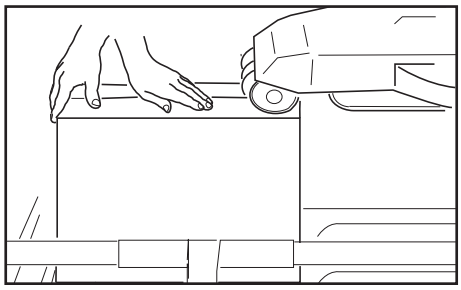
Nach der Füllung die oberen Klappen umbiegen und den Karton gegen den Hebel schieben, der den Anstieg der Klebestreifenauftrageinrichtung bewirkt.

Den Karton soweit in die Maschine schieben, bis er auf den unteren Transportriemen aufliegt.



8.2 BESCHREIBUNG DER LAUFARTEN

Die Kartonverschlußmaschine Mod. SR46-S arbeitet nur automatisch:
- Knopf Notfall-STOP;
- Betriebsknopf eingeschaltet ON.
- pneumatische Anlage aktiviert.



8.3 BESCHREIBUNG DES ABSCHALTENS DER MASCHINE

8.3.1 NORMALER MASCHINEN - STOP

Das Drücken der “AUS-Taste” am Elektroschalter bewirkt den unmittelbaren Stop des Maschinenzyklus. Eine Unterbrechung der Stromzufuhr (Stromausfall) hat den gleichen Effekt.
Die pneumatische Anlage bleibt eingeschaltet.

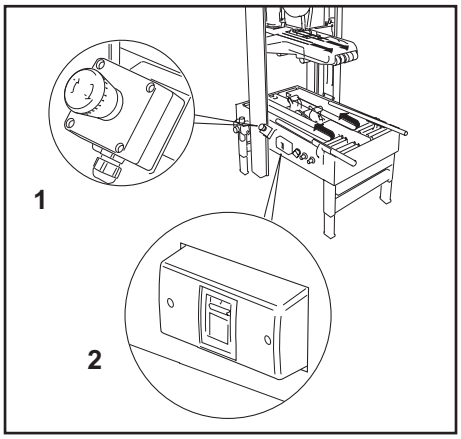
8.32 NOTABSCHALTUNG

Der Notausschalter mit mechanischer Selbstverriegelung ist montiert.
(Nicht vom Maschinenhersteller gebaute Komponente - **Siehe Kapitel 15** - Technische Eigenschaften - Anlagen).

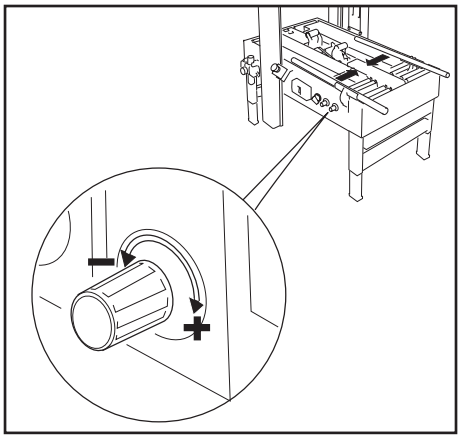
9-STEUERUNGEN IN KÜRZE

9.1 EIN- UND AUSSCHALTKNOPF (2)
Hiermit schaltet man die Kartonförderbänder ein/aus.

NOTFALL-STOP-TASTE (1)
Beendet den Arbeitszyklus der Maschine.

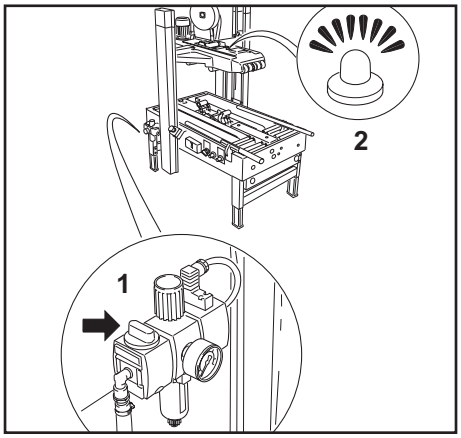


9.2 HANDGRIFF FÜR DRUCKEINSTELLUNG DER FÜHRUNGSSCHIENEN
Stellt den Druck der Führungsschienen je nach Karton ein.

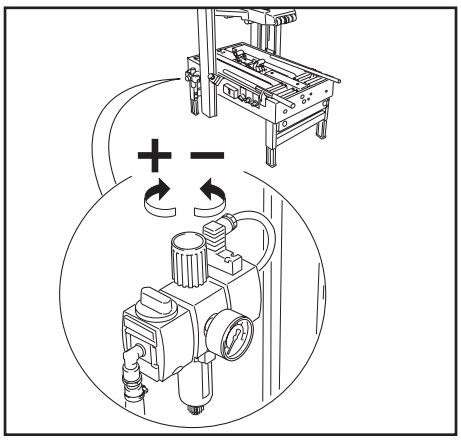


9.3 VENTIL FÜR DIE VERSORGUNG DER PNEUMATISCHEN ANLAGE (1)
Aktiviert/blockiert die pneumatische Anlage.

KONTROLL-LEUCHTE DRUCKLUFT (2)
Zeigt das Vorhandensein von Luft im Kreislauf an (roter sichtbares Signal).

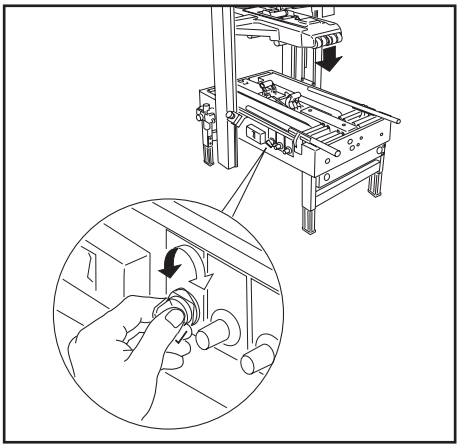


9.4 KNOPF FÜR DIE DRUCKEINSTELLUNG DER PNEUMATISCHEN ANLAGE
Erhöht/verringert den Druck im Kreislauf.



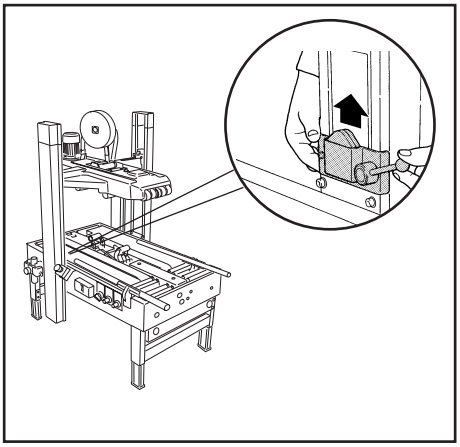
9.5 EINSTELLKNOPF FUER ANHEBEN / HERABLASSEN DES ZYLINDERKOPFES

Damit hebt/senkt sich der obere Zylinderkopf.



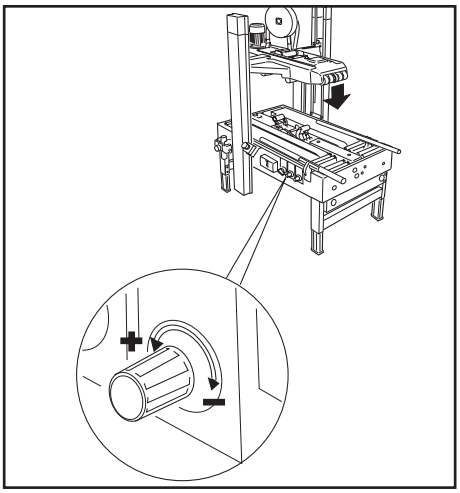
9.6 BLOCKIERUNG ZYLINDERKOPFHÖHE

Hiermit kann man den oberen Zylinderkopf gemäß der Kartonhöhe einstellen.



9.7 KNOPF FÜR DIE EINSTELLUNG DES ZYLINDERKOPFDRUCKES

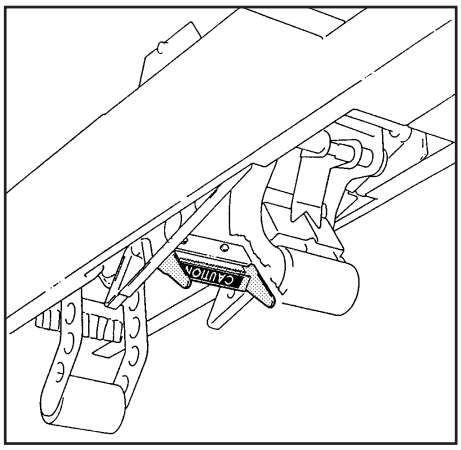
Erhöht/ verringert den Druck des oberen Zylinderkopfes (Heben) auf die Schachtel.



10-SICHERHEITSVORRICHTUNGEN

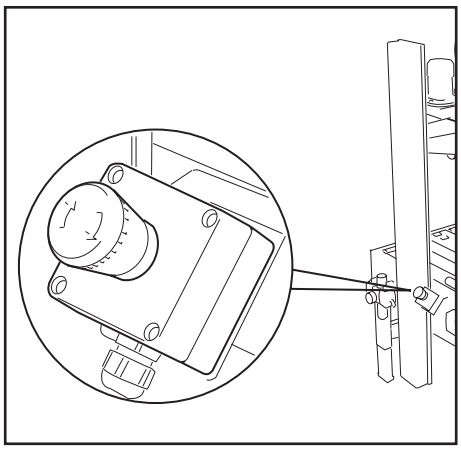
10.1 MESSERSCHUTZ

Das Schneidemesser der beiden Klebeköpfe ist durch einen federgelagerten Messerschutz gesichert.



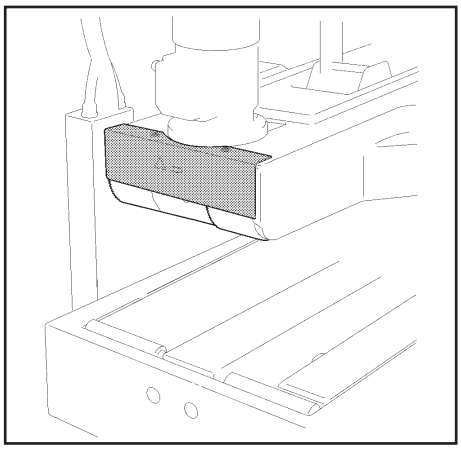
10.2 NOTAUSSCHALTER

Der Notausschalter befindet sich in einer leicht zugänglichen Position.



10.3 METALLSCHUTZVORRICHTUNG

Scutzvorrichtung der oberen Antriebsriemen.

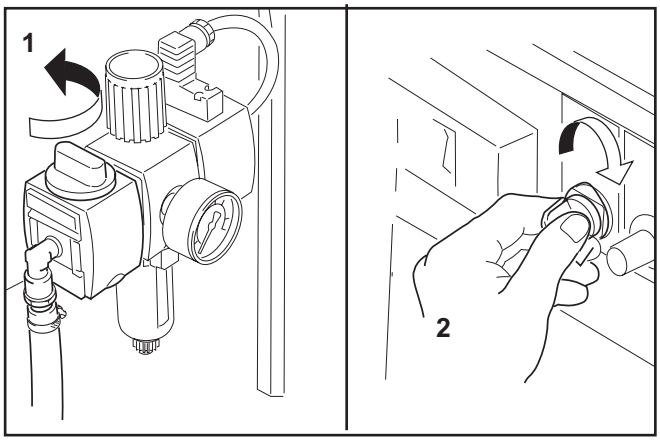


10.4 ELEKTRISCHE ANLAGE

Die elektrische Anlage ist geerdet. DieStromdurchlaß-Prüfung, sowie die Messung des Isolierwiderstandes und der Druckschlagfestigkeit gehören zur werkseitigen Qualitätskontrolle.
(siehe **Kapitel Anlagen 15.5***).*

11.0 SICHERHEIT

Alle Tätigkeiten der Vorbereitung und Einstellung dürfen nur bei gestoppter Maschine und mit verriegeltem NOTAUSSCHALTER durchgeführt werden.

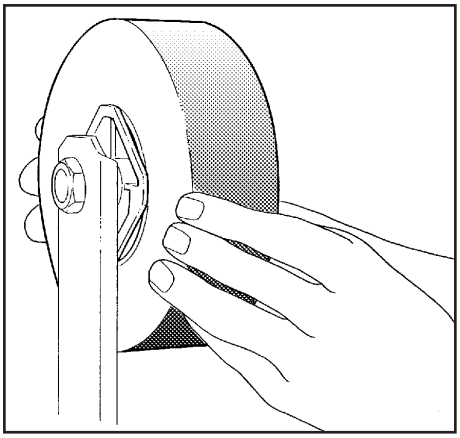


11.1 MONTAGE DES KLEBEBANDES AM OBEREN KLEBEKOPF

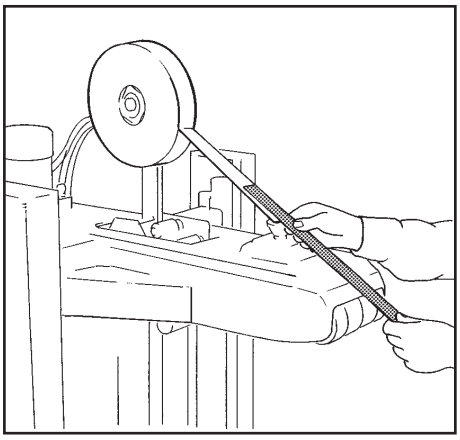
Die pneumatische Anlage anlassen, indem der Griff 1 gegen den Uhrzeigersinn gedreht wird und den oberen Zylinderkopf anheben, indem der Knopf 2 im Uhrzeigersinn gedreht wird.

.

Klebebandrolle auf Abrollkern setzen und ganz an den hinteren Abrollkern schieben.

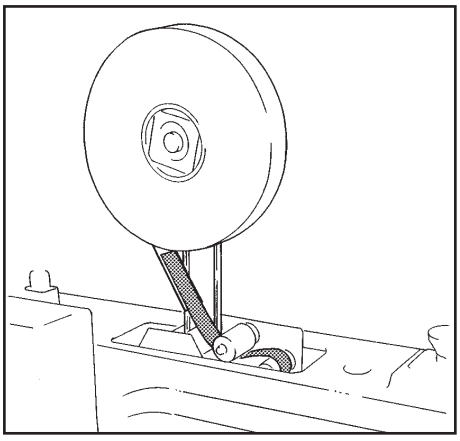


Klebeband an der hierfür vorgesehenen Einfädelhilfe ankleben.

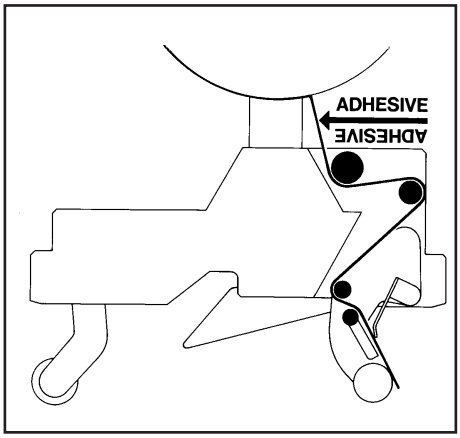


ACHTUNG! das messer ist sehr scharf, es können schwere verletzungen verursacht werden.

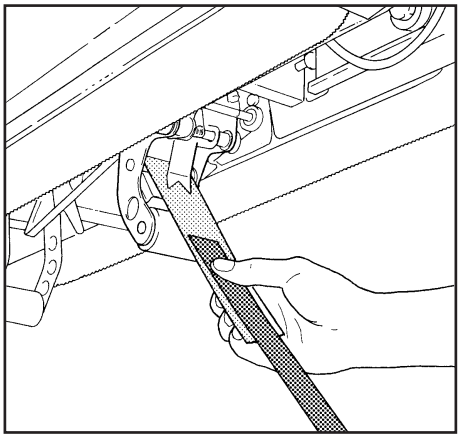
Einfädelvorrichtung in den Beklebekopf einsetzen; man muß jedoch sehr dabei aufpassen und die Hände von dem Klebebandtrennmesser entfernt halten (siehe Pkt. 3.11-g).

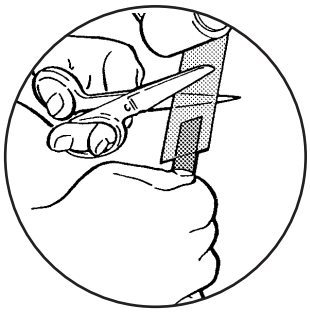


Das Klebeband gemäß dem Weg , der auf Tafel beschrieben ist, führen und dafür sorgen, daß die Klebeseite sich auf der Seite befindet, die vom Pfeil angezeigt wird.



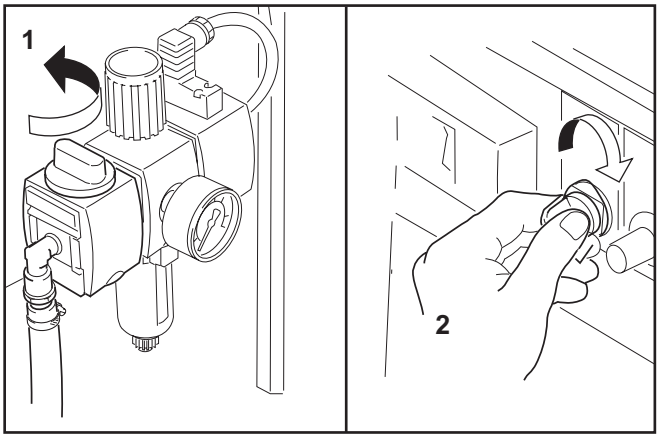
Band ziehen und den Rest abschneiden.



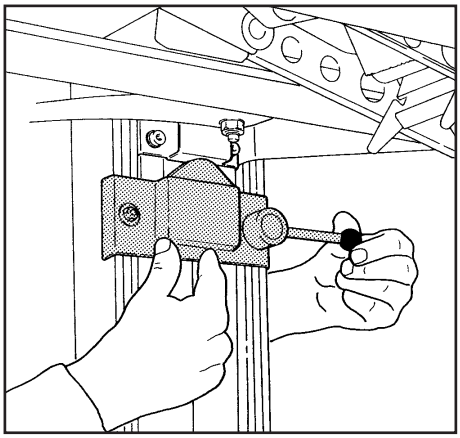


11.2 MONTAGE DES KLEBEBANDES IM UNTERER KLEBEKOPF

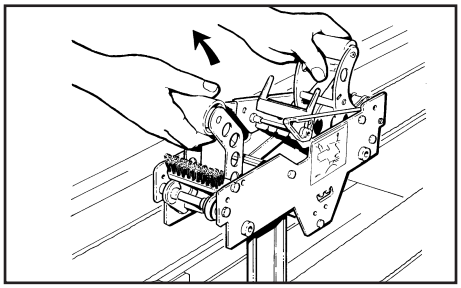
Pneumatische Anlage aktivieren, indem der Griff 1 gegen den Uhrzeigersinn gedreht wird und den oberen Zylinderkopf anheben, indem der Knopf 2 im Uhrzeigersinn gedreht wird.



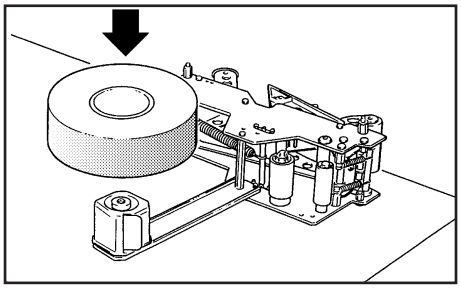
. Die Sperrung gegen den oberen Klebekopf anheben und mit dem Hebel blockieren. Nach erfolgtem Bandaustausch muß die sperrung wieder in die Originalposition gebracht werden..



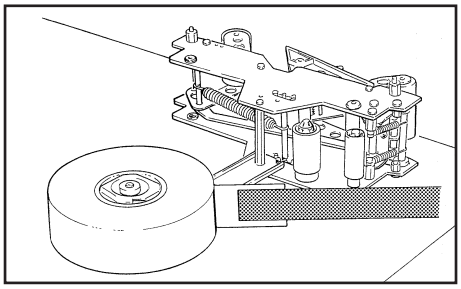
Unteren Beklebekopf aus seinem Sitz entfernen und ihn auf die Arbeitsfläche legen.



Eine Rolle Klebeband auf den Rillenhalter positionieren.

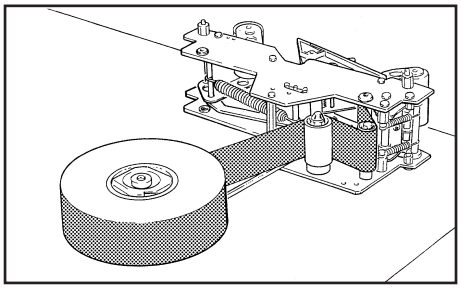


ACHTUNG! das messer ist sehr scharf , es können schwere verletzungen verursacht werden.

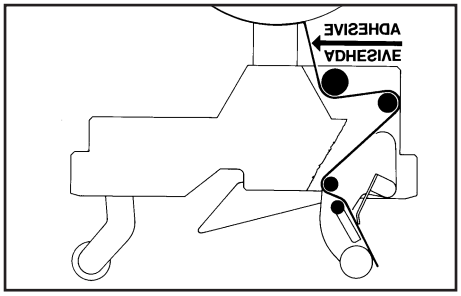


Klebeband an die Einfädelvorrichtung kleben.

Einfädelvorrichtung in den Klebekopf einsetzen und aufpassen beim Arbeiten in der Nähe des Messers (siehe Pkt. 3.11-g).

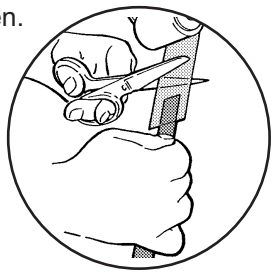


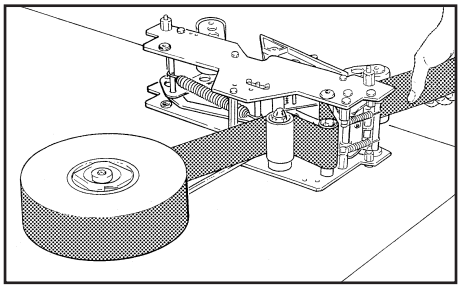
Klebeband so einfädeln und weiterführen wie es auf Bild gezeigt wird; man muß jedoch darauf achten, daß sich die Klebeseite auf der Seite befindet, die vom Pfeil angezeigt wird.



Klebeband ziehen und den Rest abschneiden.

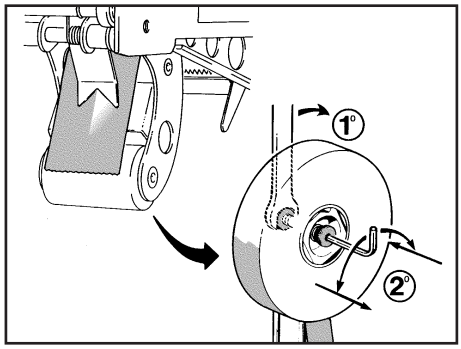
Klebekopf wieder in seinen Sitz einhängen





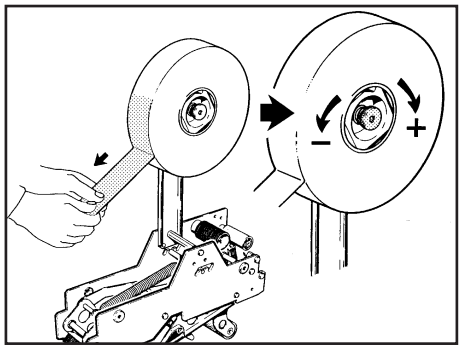
11.3 EINSTELLUNG DES KLEBEBANDHALTERS

Das Klebeband muß sich in der Mitte der Maschinenrollen befinden.
Wenn notwendig, Mutter 1 lösen und die Schraube 2 einstellen.



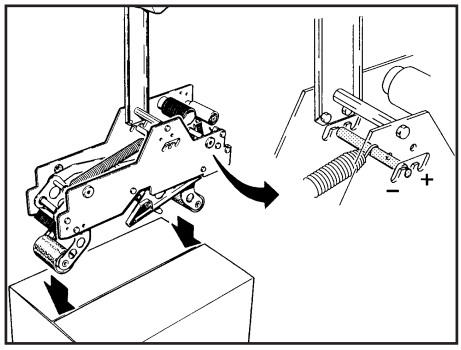
11.4 EINSTELLUNG DER BANDKUPPLUNG

Bandspannung überprüfen:
- Rollenhalter frei für Klebeband aus PVC
- Rollenhalter leicht gespannt für Klebeband aus OPP



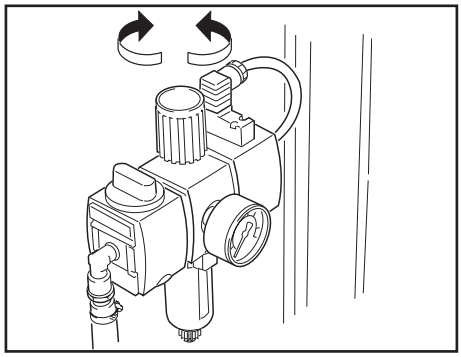
11.5 EINSTELLUNG DES KLEBEKOPFES JE NACH KARTONART

Hauptfeder einstellen:
- bei leichten Kartons weniger Druck auf die Feder ausüben;
- bei robusten Kartons mehr Druck auf die Feder süben.



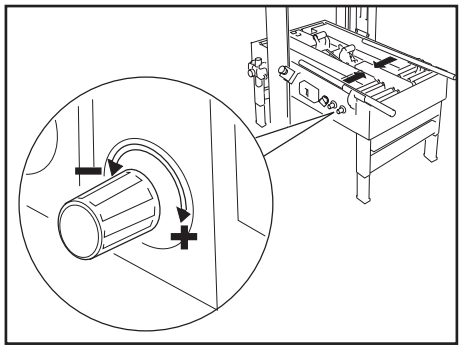
11.6 EINSTELLUNG DES DRUCKS

Den Druck gemäß der Kartonstärke einstellen.
Max. Druck 6 Bar.



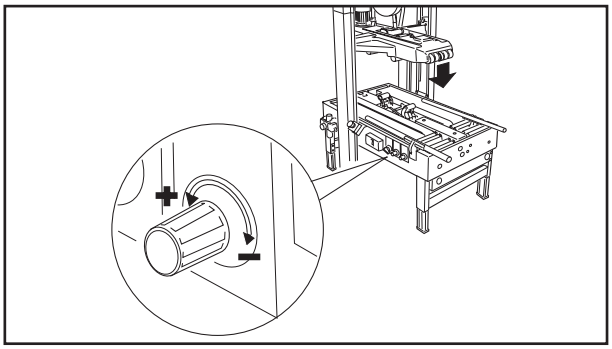
11.7 DRUCKEINSTELLUNG DER SCHIENENFÜHRUNGEN

Den Druck der seitlichen Schienenführungen auf den Kartons einstellen.
Bei leichten Kartons verringern; bei schweren Kartons erhöhen.



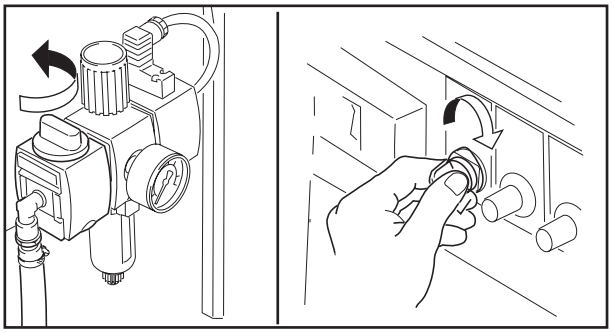
11.8 DRUCKEINSTELLUNG DES OBEREN KOPFES

Den Druck des oberen Kopfes auf dem Karton einstellen.
Bei teilweise leeren Kartons verringern; dann erhöhen, wenn ein größerer Druck auf dem Karton gewünscht wird.



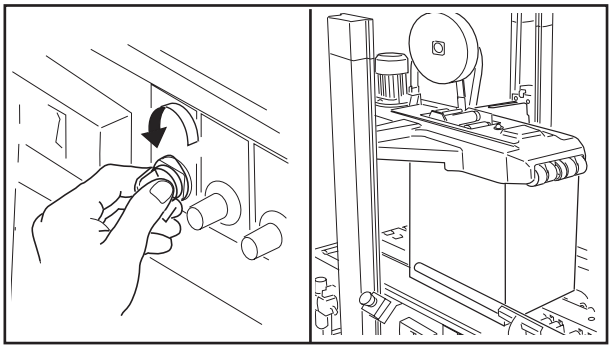
11.9 SENKEINSTELLUNG DES OBEREN KOPFES (SCHNELLERE PRODUKTION)

Unter normalen Bedingungen senkt sich der obere Kopf bis zu einer Mindesthöhe von 110 mm nach jedem Verschlußzyklus. Es ist möglich, das Senken des oberen Kopfes zu beschränken, wenn:
a) man Kartons mit verschiedenen Abmessungen verschließt und man die Mindesthöhe innerhalb dieser verschiedenen Abmessungen kennt.
b) man viele Kartons mit gleichen Abmessungen schließt und die Produktion dieser vielen Kartons beschleunigen möchte.

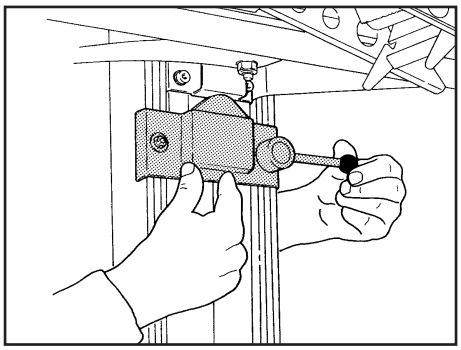


Um die Mindesthöhe des Kopfes einzustellen, geht man wie folgt vor:

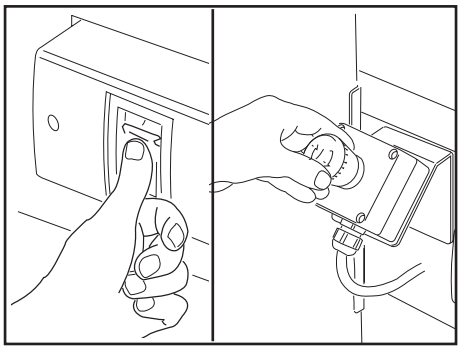
Den Schalter im Uhrzeigersinn drehen, damit sich der Kopf hebt.
Den zu verschließenden Karton einsetzen und den Schalter gegen den Uhrzeigersinn drehen, wobei der Kopf sich senkt, bis er auf dem Karton aufliegt..



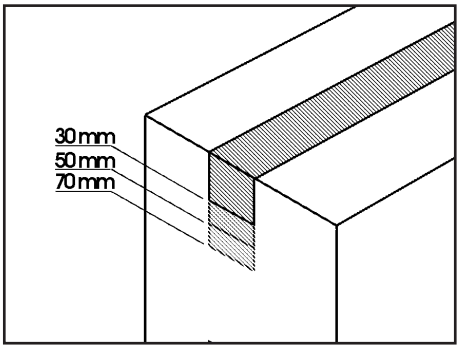
Die Sperrung gegen den oberen Kopf bringen und mit dem entsprechenden Griff blockieren.



Den Notstopschalter im Uhrzeigersinn drehen und die Taste ON drücken.
Der Karton wird nun von den oberen und unteren Förderbändern gezogen, verschlossen und von der Maschine abgestoßen.



BESONDERE EINSTELLUNGEN



11.10 VERÄNDERUNG DER KLEBEBANDSCHENKELLÄNGE

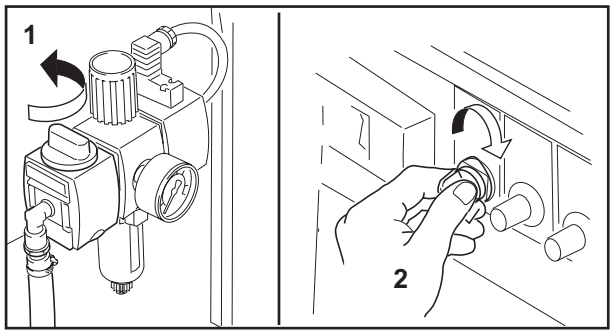
Die Schenkellänge des Klebebandes kann von 70 , 50 bis 30 mm variieren.

Für diese Art von Einstellung muß man sich auf das Handbuch der Kartonverschließmaschine K12 beziehen, das mit der Maschine geliefert wurde..

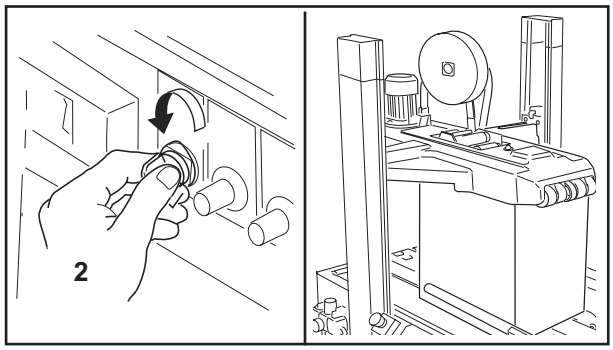
11.11 FESTE SÄULEN IN HOHER POSITION

Um Kartons, die höher sind als 750 mm und bis 930 mm gehen, verschließen zu können, ist es notwendig, daß man die Säulen der Maschine anhebt. Bei dieser Arbeit muß man folgendermaßen vorgehen:

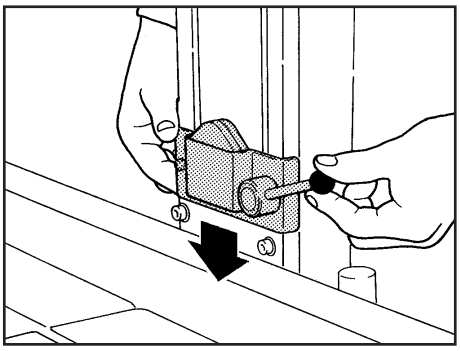
die pneumatische Anlage aktivieren, indem der Knopf **1** gegen den Uhrzeigersinn gedreht wird und den oberen Zylinderkopf anheben, indem der Wahlknopf **2** im Uhrzeigersinn gedreht wird.



Anschliessend muss man einen Karton (Höhe ca. 450 mm), der ausreichend robust ist, um das Gewicht (45 kg) des Zylinderkopfes auszuhalten, unter den Zylinderkopf schieben.
Dann den Wahlschalter 2 gegen den Uhrzeigersinn drehen und den Zylinderkopf herabschrauben bis er auf der Stütze aufliegt.

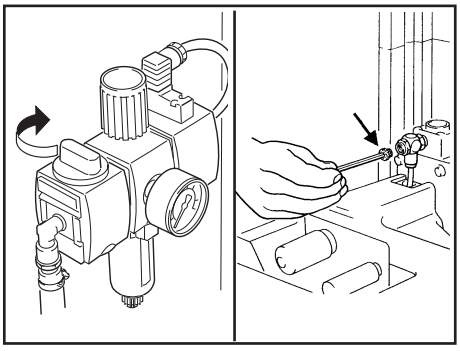


Blockierung vollkommen lösen und herablasssen.



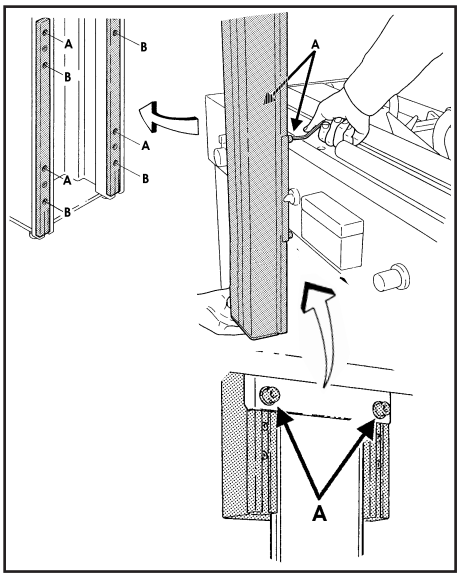
Pneumatische Anlage disaktivieren, indem der Knopf im Uhrzeigersinn gedreht wird.

Deckel abnehmen und die gesamte Druckluft aus der pneumatischen Anlage ablassen. Den Deckel wieder festschrauben.



Mit der einen Hand die Säule halten und mit der anderen Hand die 4 Schrauben (A) entfernen; die Säule so hoch drücken, bis sie die Höhe der Löcher (B) erreicht. Schrauben wieder einsetzen.

Pneumatische Anlage wieder aktivieren.



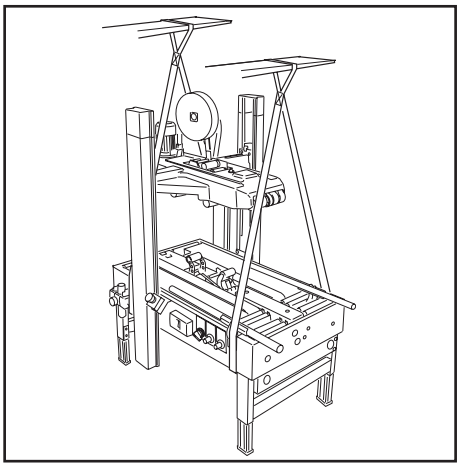
SONDERZUBEHOER

11.12 ZUSÄTZLICHER RÄDERSATZ (AS 77)

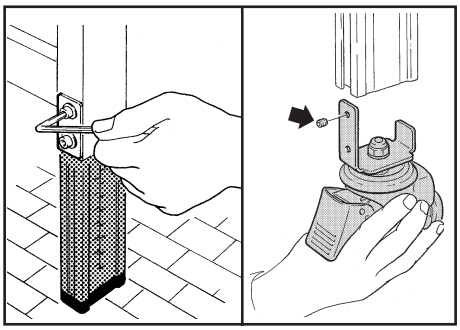
(Bestellnummer: 7.8.04337.00B)

Man kann 4 Räder montieren, um so die Maschine leichter bewegen zu können; aus diesem Grund variieren die Höhe der Rollenplatte und die allgemeinen Abmessungen
(siehe Abschnitt 4.7).

Maschine anheben, so wie es auf Tafel gezeigt wird .



Die Füßchen entfernen, die Räder einsetzen und mit den beiden Dübeln befestigen und dann die Höhe der Rollenplatte wieder herstellen, indem man auf die angezeigte Höhenskala bezug nimmt.
(Radhöhe = 100 mm)

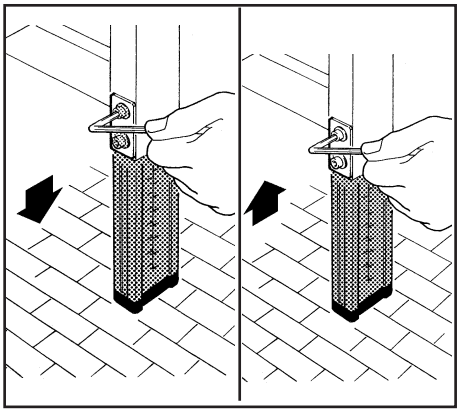


11.13 SONDERZUBEHÖR BEINSATZ H = 600 (AS80)

(Bestellnummer: 7.8.04413.00A)
Um die Rollenplatte anheben zu können, so wie es in der Tabelle auf gezeigt wird, ist es notwendig, die Beine auszutauschen.

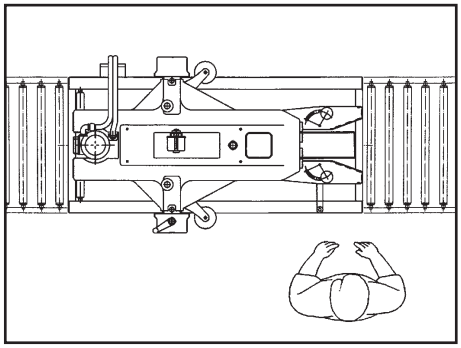
Maschine anheben, wie auf Tafel dargestellt wird, Schrauben lösen und Beine herausziehen.

Neue Beine einsetzen und in bezug auf die angezeigte Höhenskala blockieren.



12-INBETRIEBNAHME

12.1 KORREKTE POSITION/STANDORT DES MASCHINENBEDIENERS



12.2 INBETRIEBNAHME DER MASCHINE

"EIN"-Taste des Hauptschalters drücken.

12.3 PRODUKTIONSAUFNAHME

Bevor die Produktion aufgenommen wird, sollte man die Maschine leer laufen lassen und die Sicherheitsvorrichtungen prüfen (siehe Abschnitt 12.8). Danach den Arbeitszyklus beginnen.

12.4 ROLLENWECHSEL KLEBEBAND

Vorsicht beim Arbeiten in der Nähe des Schneidemessers.

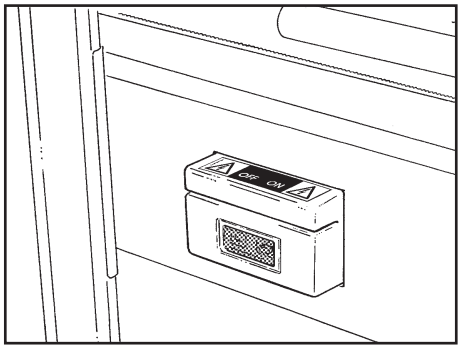
Qualifikation 1 Maschinenbediener

Jedesmal, wenn die Rolle ausgetauscht werden soll, folgendermaßen vorgehen:

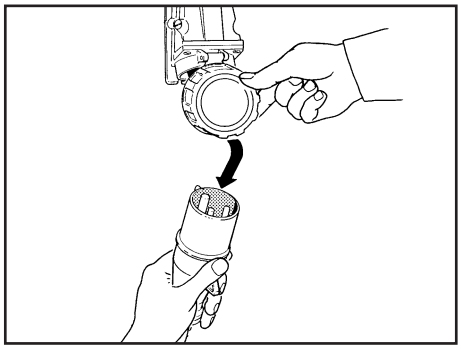
- NOTAUSSCHALTER drücken;
- Alle Arbeitsschritte, die in den Pkt. 11.1 und/oder 11.2 beschrieben wurden, wiederholen

12.5 REINIGUNG

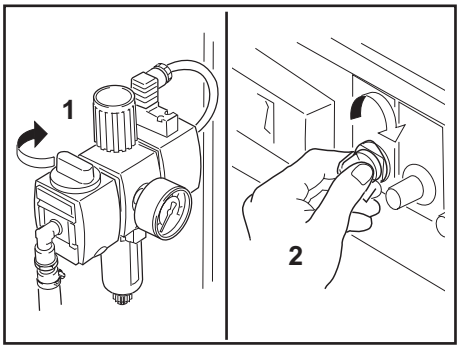
Bevor Pflege-und Wartungsarbeiten ausgeführt werden, muß die Maschine angehalten werden, indem man die Taste auf dem Hauptschalter drückt.



Stecker aus dem Elektroschaltbrett ziehen.



Pneumatische Anlage aktivieren, indem der Griff **1** gegen den Uhrzeigersinn gedreht wird und oberen Zylinderkopf anheben, indem der Wahlknopf **2** im Uhrzeigersinn gedreht wird.
Den Zylinderkopf mit dem Zapfen blockieren.



REINIGUNG - Qualifikation **1**
Trockene Lappen oder verdünnte Reinigungsmittel verwenden.

Keine Lösungsmittel oder Wasserstrahl verwenden.

12.6 ZUSAMMENFASSENDE TAFEL DER EINSTELLUNGEN

ARBEITSBESCHREIBUNG	QUALIFIKATION	KAPITEL
Bandwechsel	**1**	**11.1 - 11.2**
Einstellung Bandzentrierung	**1**	**11.3**
Kontrolle der Sicherheitsvorrichtungen	**1**	**12.7**
Einstellung Klebebandkupplung	**1**	**11.4**
Einstellung Senken oberer Kopf	**1**	**11.9**
Einstellung Anwendungsdruck beim Band	**1**	**11.5**
Höheneinstellung von d. Erde	**1**	**7.4**
Luftdruck	**1**	**9.3**
Spezialeinstellungen: Klebebandschenkel	**2**	**11.10**
Spezialeinstellungen: Feste Säulen in hoher Position	**2**	**11.11**

12.7 PRÜFUNG DER FUNKTIONSTÜCHTIGKEIT DER SICHERHEITSVORRICHTUNG

1 Messerschutz des oberen und unteren Beklebeschutzes (Abschnitt 10.1)
2 Notausschalter mit mechanischer Selbstverriegelung (Abschnitt 10.1)
3 STOP - Drucktaste " am Elektrohauptschalter
(Abschnitt 7.11.3, Abschnitt 9.1)

12.8 STÖRUNGSANALYSE

PROBLEM	URSACHE	ABHILFE
Die Maschine läßt sich mit der "EIN-Drucktaste nicht ingangsetzen.	Der NOTAUSSCHALTER ist gedrückt. Kurzschluss in d.elektr. Anlage.	NOTAUSSCHALTER entriegeln, indem man den Kanuf im Uhrzeigersinn dreht. Elektr. Anlage testen.
Die magnetothermische Schutzvorrichtung öffnet den Hauptschalter.	Überhitzter Motor. Zu niedrige Eichung der Thermik im Hauptschalter.	Prüfen, ob die Transportbänder nicht blockiert sind. Prüfen, ob die Stromaufnahme, die auf dem Schild der Motoren angegeben ist, nicht höher als der Wert ist, der auf der thermischen Einrichtung eingestellt ist..
Motor funktioniert, aber Transportbänder halten.	Transportbänder gelockert. Motorriemenscheiben abgenutzt.	Einstellung d. Spannung. Abnutzungszustand der Ringe kontrollieren und eventuell austauschen.
Die Transportbänder bewegen sich, Karton wird nicht mitgenommen.	Transportbänder abgenutzt.	Bänder ersetzen.
Oberer Zylinderkopt senkt sicht nicht oder senkt sich zu langsam/schnell.	Wahlschalter "Ansteigen/Sinken" nicht eingeschalter. Es ist die Fabrikeinstellung verändert worden.	Gegen den Uhrzeigersinn drehen. Druck einstellen.

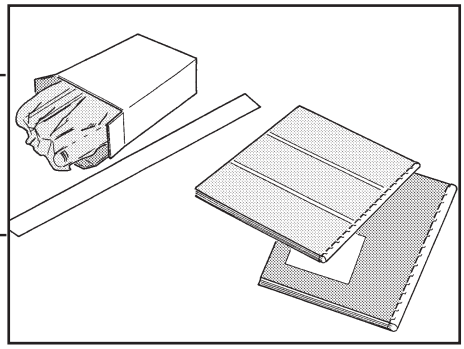
13-WARTUNG UND REPARATUREN

13.0 SICHERHEITSHINWEISE

(Siehe Punkt 3)

Die Durchführung von Wartungs- und Reparaturarbeiten kann Gefahrensituationen mit sich bringen. Die Entwicklung dieser Maschine basiert auf den Normen EN 292 Nov.92/6.1.2. und EN 292/2 Nov.92/5.3.

13.1 WERKZEUGE UND ERSATZTEILE, DIE MIT DER MASCHINE GELIEFERT WERDEN



1 Nr. 1 Schneidemesser (Ersatzschneidemesser für die Kartonverschließmaschine Bestellnr. S4004152ZZZ);
Nr. 1 Hauptfeder UNTEN (Bestellnr. S370017992Z);
Nr.1 Hauptfeder OBEN (Bestellnr. S370017894Z);
Nr. 2 Feder Schneidevorrichtung (Bestellnr. S37022794Z);
2 Einfädelhilfe (um das Klebeband in die Maschine einzufädeln, Bestellnr. S310091406Z);
3 Handbuch der Maschine (Bestellnr. SMB00049K)
4 Handbuch des Klebekopfes (Bestellnr. S300024296A).

13.2 ART UND HÄUFIGKEIT DER WARTUNGS-SERVICEARBEITEN

Arbeitsbeschreibung	Häufigkeit	Qualifikation	Kapitel
Schmierung	vierteljährlich	2	13.5-6-7
Messerreinigung	wöchentlich	2	13.8
Maschinenreinigung	wöchentlich	1	12.5
Kontrolle d. Sicherheitsvorrichtungen	täglich	1	13.4
Messeraustausch	//	2	13.9
Austausch d. Transportbänder	//	2	13.10

13.3 KONTROLLMASSNAHMEN VOR UND NACH JEDER WARTUNGSARBEIT

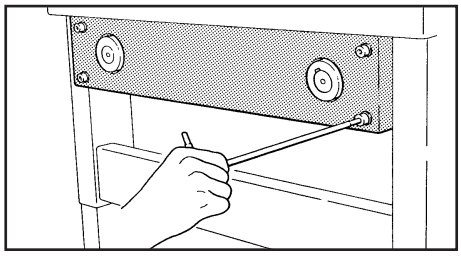
Bevor irgendwelche Unterhalts-und Wartungsarbeiten vorgenommen werden, muß die “AUS”-Taste des Hauptschalters gedrückt und die Stromzufuhr unterbrochen werden.
Während der Wartungsarbeiten darf sich nur die für die Arbeit verantwortliche Person an der Maschine betätigen.
Nach Beendigung der Arbeit muß die Funktionstüchtigkeit aller Sicherheitsvorrichtungen überprüft werden.

13.4 KONTROLLE WIRKSAMKEIT DER SICHERHEITSVORRICHTUNGEN

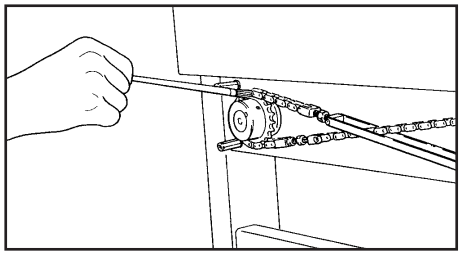
1 Messerschutz des Beklebekopfes (Abschnitt 10.1)
2 Funktion NOTAUSSCHALTER Abschnitt 10.1)
3 STOP-Drucktaste (AUS) am Elektrohauptschalter (Abschnitt 7.11.3 und Abschnitt 9.1)

13.5 MASCHINENSCHMIERUNG

Deckel abnehmen

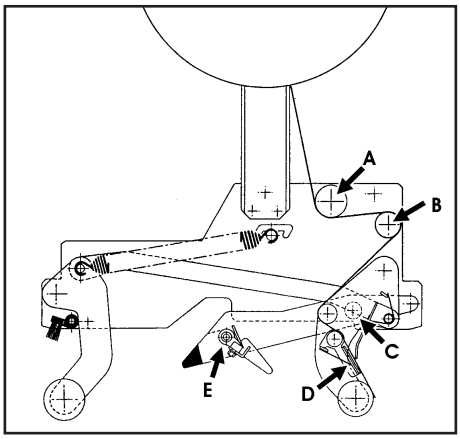


Kette schmieren und vierteljährlich die Ritzel mit Fett /Metall/Metall einfetten..



13.6 PRODUKTE FÜR DIE SCHMIERUNG

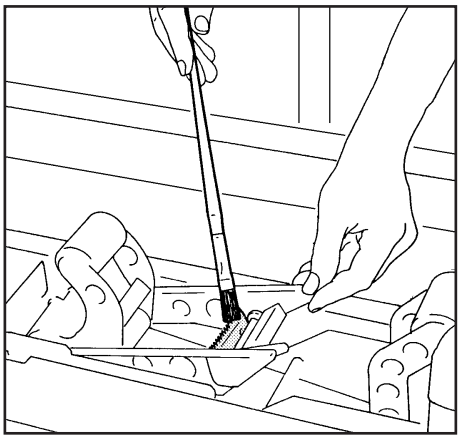
Fett-Typ:
Metall/Metall: B.C. 190 Haevy Duty (oder fett für Ketten und Kugellager)
Metall/Plastik: Plate Master M+L (Fett mit Molybden und PTFE für Materialien aus Plastik und Metall)
ÖI:
Normales Schmieröl oder ein wasserabstoßendes Öl in Form von einem Mehrzweckspray.



13.7 SCHMIERUNG DES KLEBEKOPFES

Monatlich die Punkte mit Öl schmieren, die auf Tafel angegeben sind.

A Zapfen f. Federhalterung
B Zapfen f. Federspannung
C Zapfen f. Rolle Nicht-Rücklauf
D Gelenk fuer Messerhalter
E Zapfen f. Messerschutz

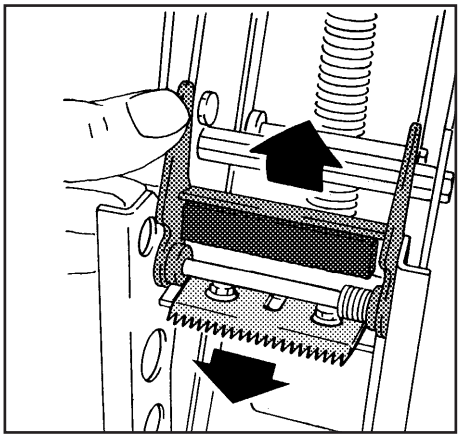


13.8 MESSERREINIGUNG

Qualifikation Maschinenbediener **2**
Schutzvorrichtung anheben und Messer mit einem Pinsel (mit langem Griff) und Öl reinigen. Das Öl verhindert, daß sich Klebekrümel bilden.

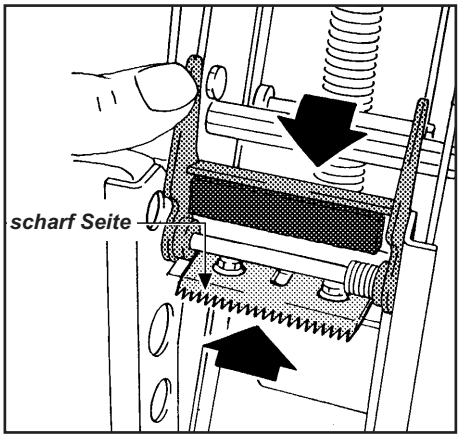
13.9 MESSERAUSTAUSCH

Qualifikation Maschinenbediener **2.**
- Messerschutzvorrichtung, wie auf Tafelgezeigt wird, anheben.
- Schrauben lockern.
- Messer herausnehmen.



ACHTUNG!
Das Messer ist sehr scharf.
Fehler während dieser Arbeit können schwerwiegende Verletzungen verursachen.

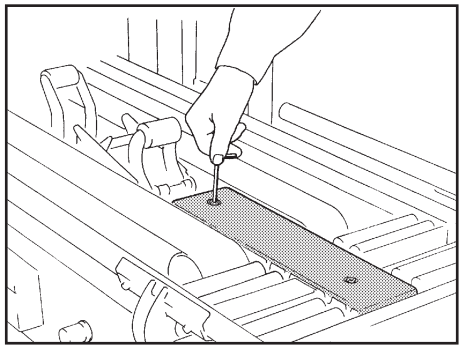
-Neues Messer einsetzen und darauf achten, daß sich die Schneide in der korrekten Position befindet.
- Schrauben wieder anziehen.
- Schutzvorrichtung wieder loslassen.



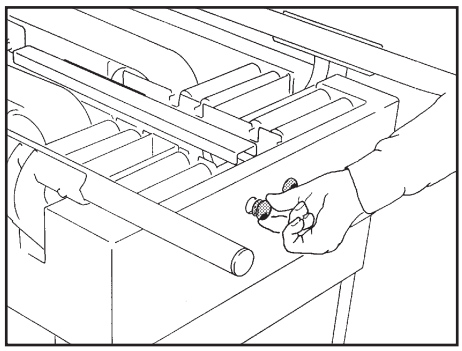
13.10 AUSTAUSCH DER UNTEREN TRANSPORTBÄNDER

Qualifikation Maschinenbediener **2**

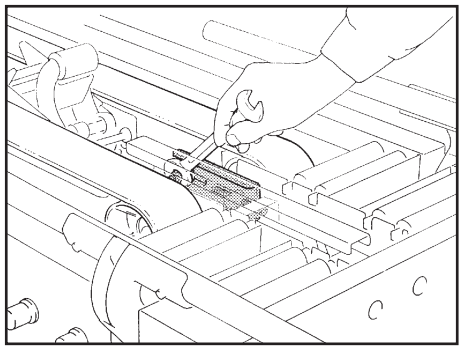
- die 2 Schrauben entfernen.
- Carter entfernen.



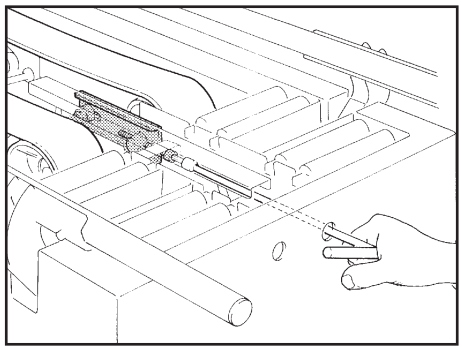
- beide Stöpsel entfernen.



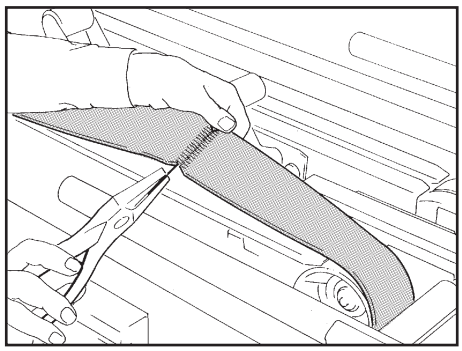
- Blockiermutter lösen.



- Spannungsschraube lösen.



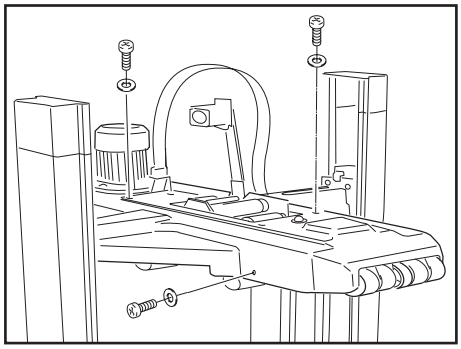
- Mit Cutter das abgenutzte Band durchschneiden.
- Neues Band einsetzen.
- Zwischen den Verbindungsgliedern einen Nylonzapfen einsetzen.
- Spannung des Transportbandes einstellen.



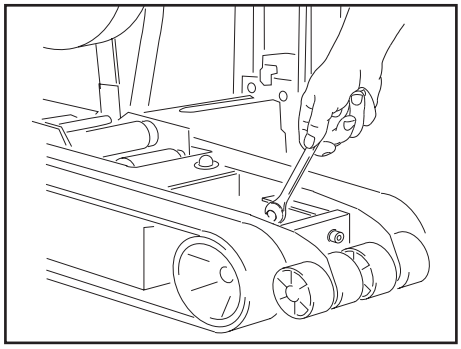
13.11 AUSTAUSCH DER OBEREN TRANSPORTBÄNDER

Qualifikation Maschinenbediener 2

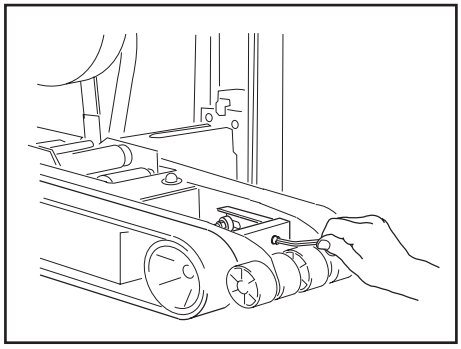
- Die zehn Schrauben, die den carter halten, lösen und den carter entfernen.



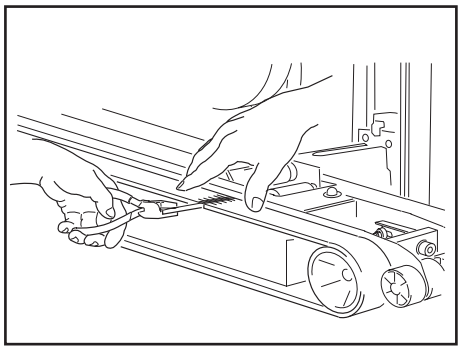
- Die Blockierungsmutter lösen.



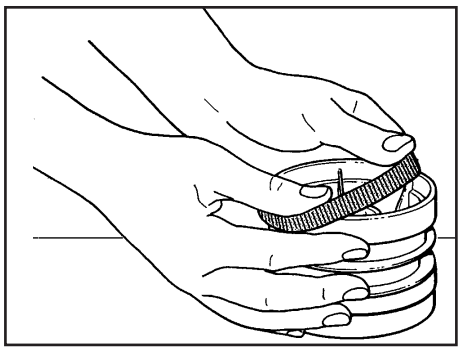
- Die Spannungsschraube lösen.



- Mit Cutter das abgenutzte Band durchschneiden.
- Neues Band einsetzen.
- Zwischen den Verbindungsgliedern einen Nylonzapfen einsetzen.
- Spannung des Transportbandes einstellen.

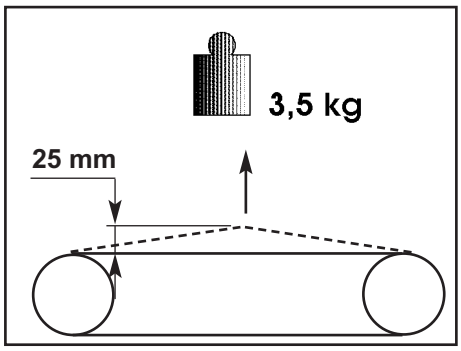


ACHTUNG!
Bevor das neue Transportband montiert wird, muß man den Zustand der Ringe aus orangem Plastik auf den Motorriemenscheiben kontrollieren: bei Abnutzung müssen sie ausgetauscht werden.



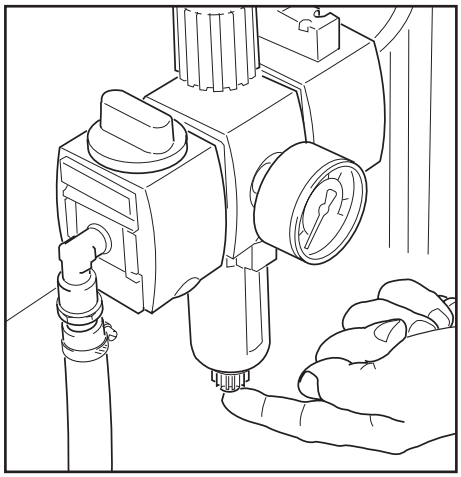
13.2 EINSTELLUNG TRANSPORTBANDSPANNUNG

Transportbandspannung kontrollieren, indem das Band in der Mitte angehoben wird; es muß ungefähr 25 mm mit einer Zugkraft von 3,5 kg angehoben werden können.



WICHTIG!

Jedesmal, wenn sich Kondenswasser im Filter ansammelt, muß man es entfernen, indem man einen einen leichten Druck auf den unteren Teil des Bechers ausübt.



13-WARTUNG UND REPARATUREN

AUFSTELLUNG / LISTE DER REPARATUREINGRIFFE, DIE AN DER MASCHINE DURCHGEFÜHRT WORDEN SIND

DATUM	***BESCHREIBUNG DES EINGRIFFES***

14-SCHLUSSBEMERKUNGEN

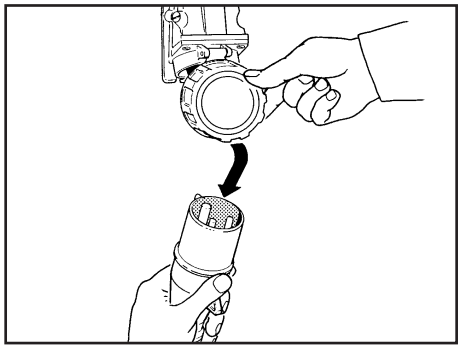
14.1 MASCHINENENTSORGUNG

Die Maschine setzt sich aus folgenden Materialien zusammen:
- Stahlstruktur;
- Nylonrollen;
- PVC-Antriebsbänder;
- Nylon-Riemenscheiben.

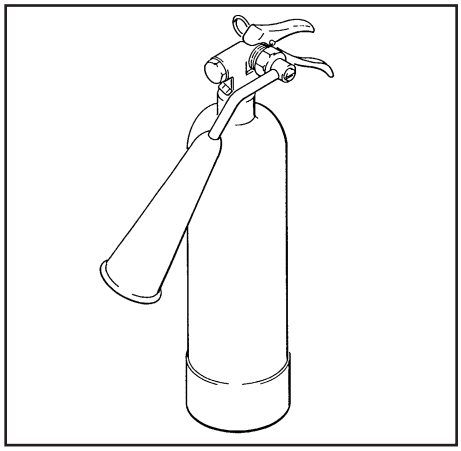
Im Falle einer Entsorgung von Materialien, aus denen die Maschine besteht: man muß sich gemäß den geltenden Vorschriften des Landes verhalten.

14.2 VORGEHEN IM NOTFALL

Im Falle von Gefahr /Feuer:
Maschinenkabel aus der Steckdose ziehen.



IM BRANDFALL
Bei Feuerausbruch CO2 - Feuerlöscher einsetzen.
Kein Wasser verwenden.



15-ANLAGEN

15.1 KONFORMITÄTSERKLÄRUNGEN

mit Maschinenrichtlinien 98/37 CEE , 91/368, 93/44 und 93/68.

15.2 LABEL FÜR SICHERHEITSVORRICHTUNGEN

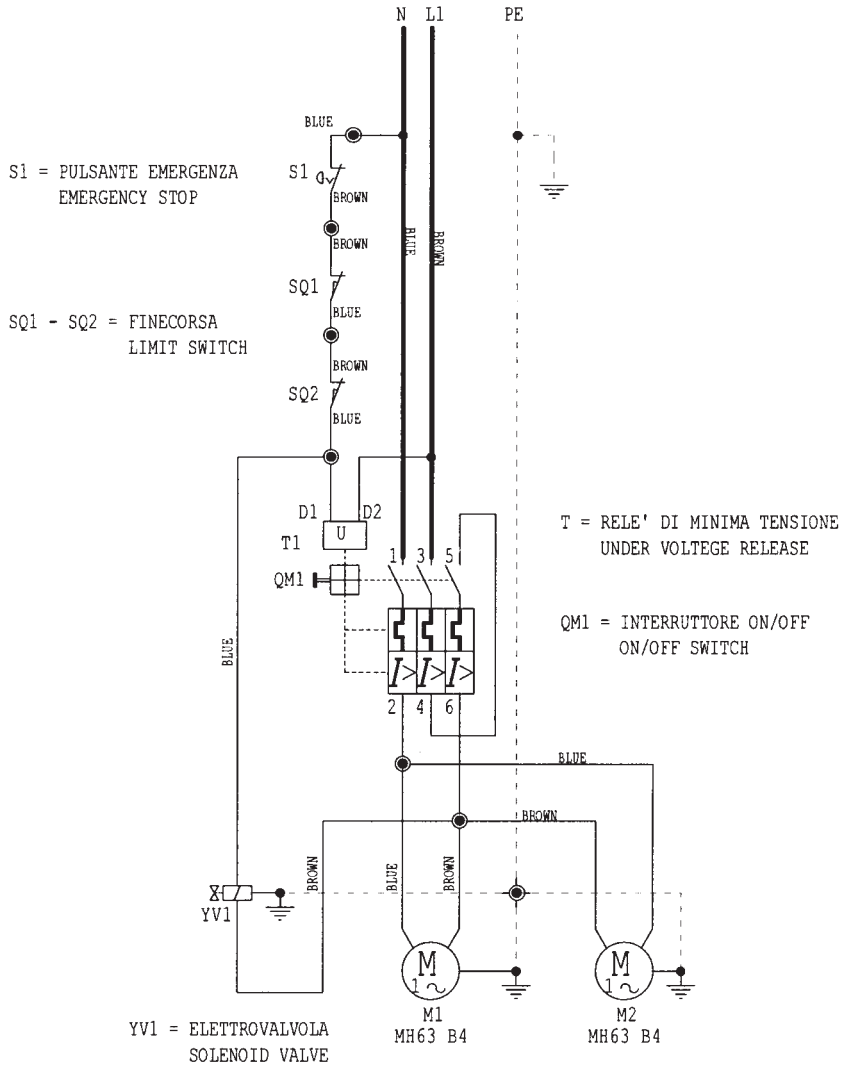
Die Etiketten, die an der Maschine angebracht sind, sind für die Sicherheit des Maschinenbedieners wichtig. Falls eines dieses Labels beschädigt oder entfernt worden ist, unterliegt es der Verantwortung des Benutzers, dieses Schild sofort zu ersetzen.
Fuer die Bestellung dieser Ersatzetiketten muß man sich auf die Bestellnummern beziehen, die im Bild 5709 des Ersatzteilekatalogs aufgezeigt werden.

15.3 ANGABEN ÜBER STRAHLUNG, ABGASE, DÄMPFE, STAUB USW

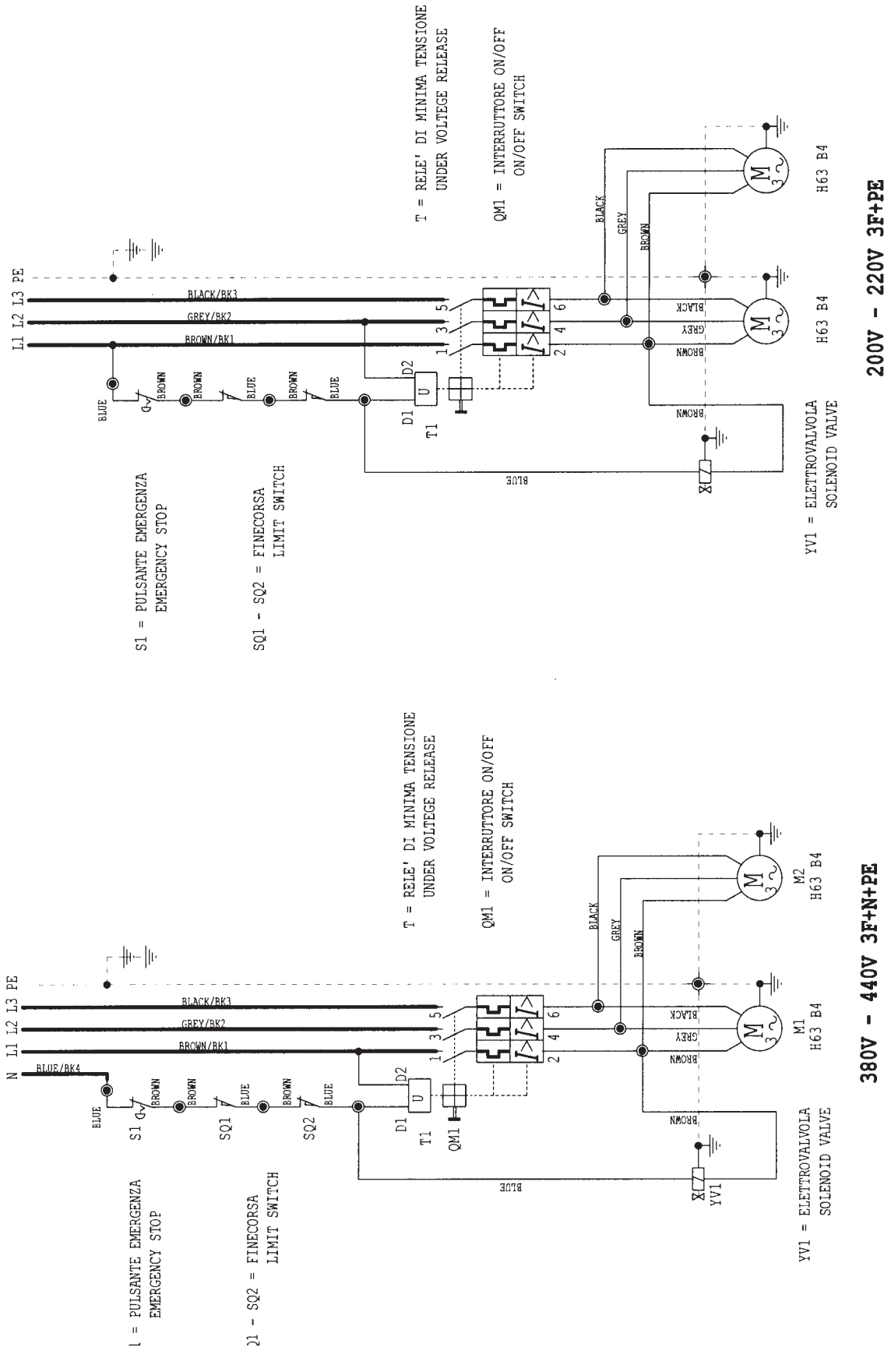
Keine Angaben

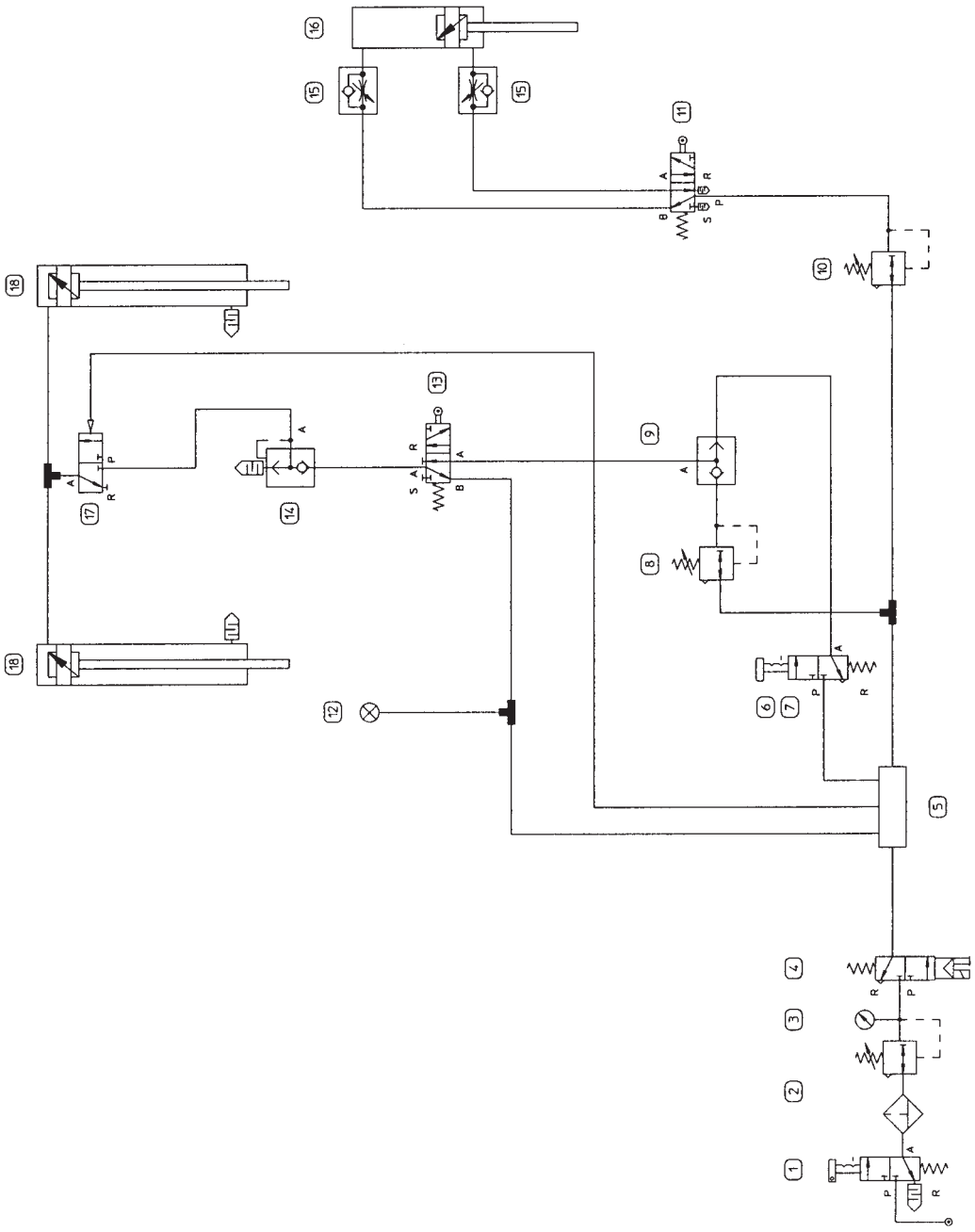
15.4 ELEKTRISCHE TESTS

Elektrische Tests:
1 - Stromdurchlaßprüfung
2 - Isolierwiderstand
3 - Isolierspannung
Ref.: EN 60204-1, PAR. 20.2, 20.3, 20.4



100V - 240V MF+PE


200V - 220V 3F+PE
380V - 440V 3F+N+PE
T = RELE' DI MINIMA TENSIONE
UNDER VOLTEGE RELEASE
QM1 = INTERRUTTORE ON/OFF
ON/OFF SWITCH
S1 = PULSANTE EMERGENZA
EMERGENCY STOP
SQ1 - SQ2 = FINECORSA
LIMIT SWITCH
YV1 = ELETTROVALVOLA
SOLENOID VALVE
L1 L2 L3 PE
N L1 L2 L3 PE
BLACK/BK3
GREY/BK2
BROWN/BK1
BLUE/BK4
BLACK
GREY
BROWN
BLUE
M1
M2
H63 B4
D1
D2
T1
QM1
S1
SQ1
SQ2
YV1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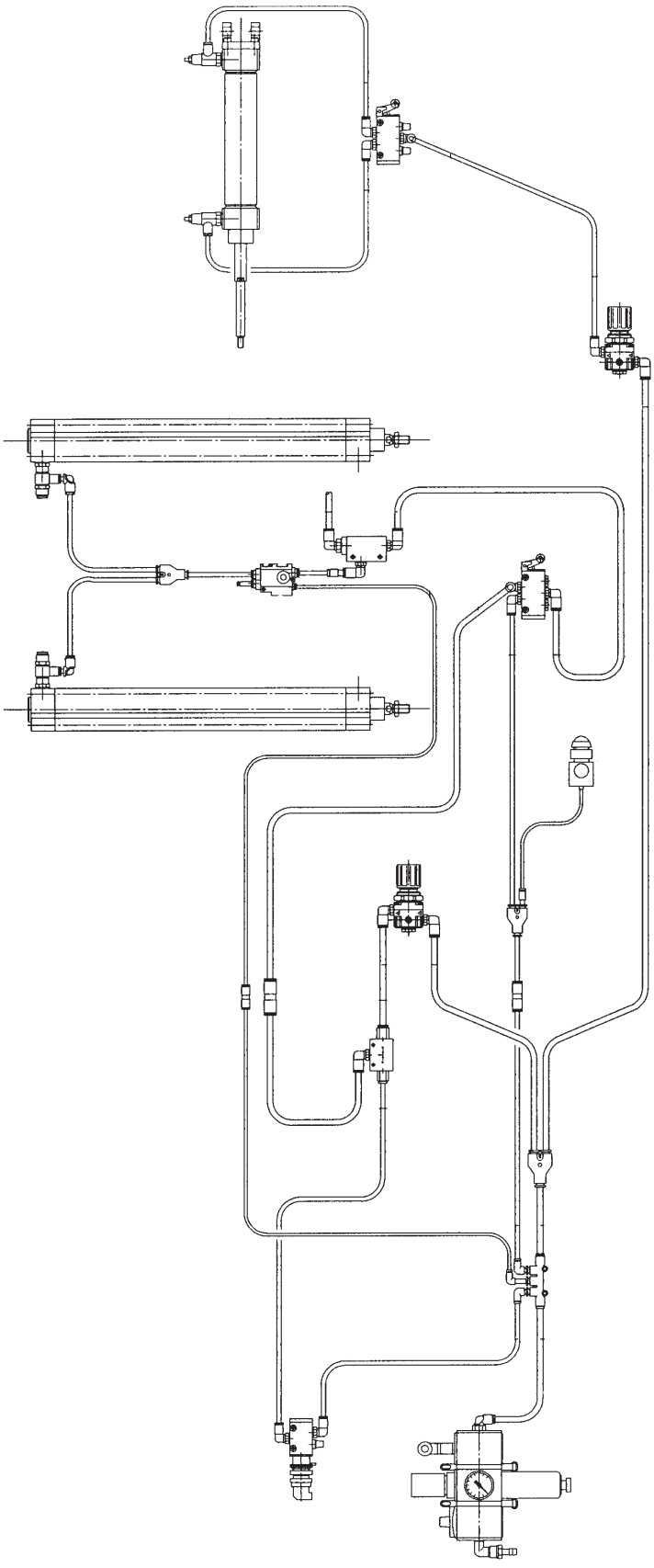

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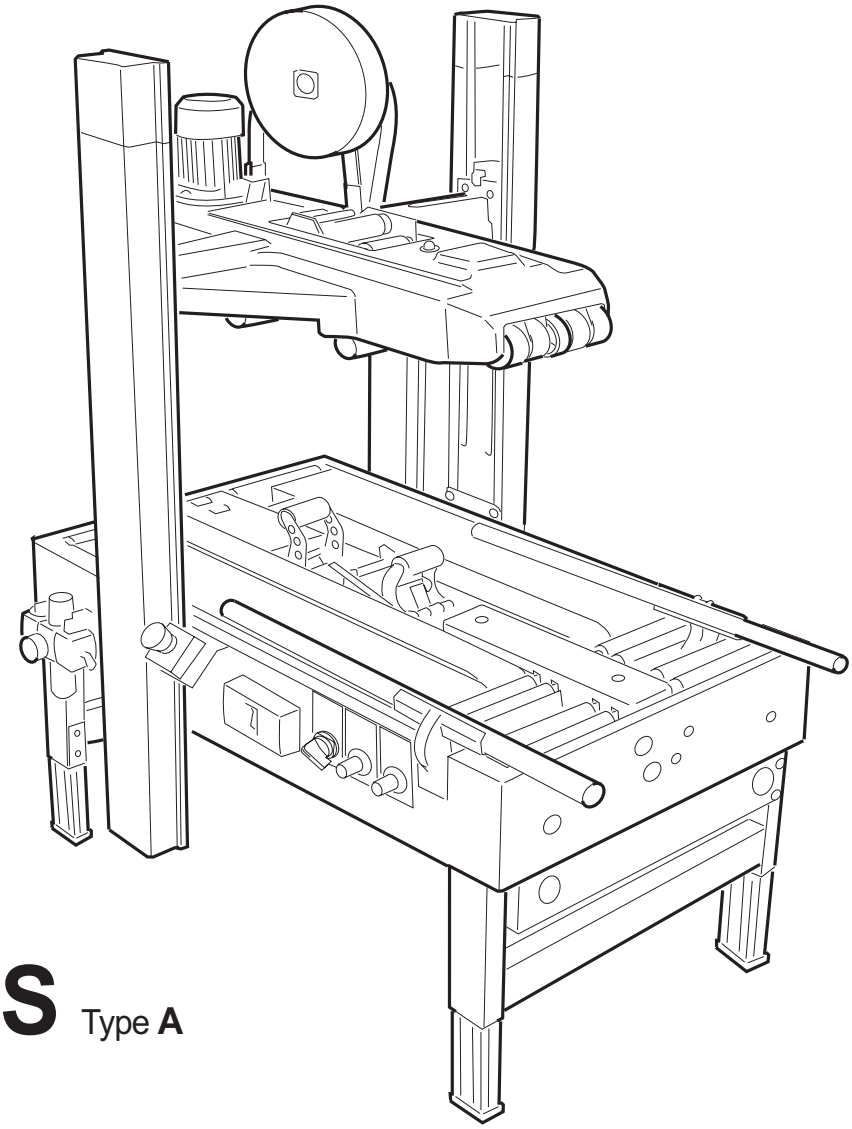

SR46-S Type **A**

NASTRATRICE AUTOMATICA
AUTOMATIC CASE SEALING MACHINE
MACHINE ENRUBANNEUSE AUTOMATIQUE
AUTOMATISCHE KARTONVERSCHLIESSMASCHINE
PRECINTADORA AUTOMATICA

MANUALE DI ISTRUZIONI E PARTI DI RICAMBIO
INSTRUCTIONS MANUAL AND SPARE PARTS LIST
MANUAL D'INSTRUCTIONS ET PIECES DETACHEES
BEDIENUNGSANLEITUNG UND ERSTAZTEILLISTE
MANUAL DE INSTRUCCIONES Y RECAMBIOS

CE

Publicación no.: SMB00049K

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http://www.siat.com - E-Mail: siat@siat.com

Manual de instrucciones para el uso, seguridad, mantenimiento y piezas de recambio de la precintadora SR46-S Tipo A.

Publicación de propiedad de SIAT S.A., calle Puecher 22-22078 Turate (CO) - Italia.

Edición Enero 2007

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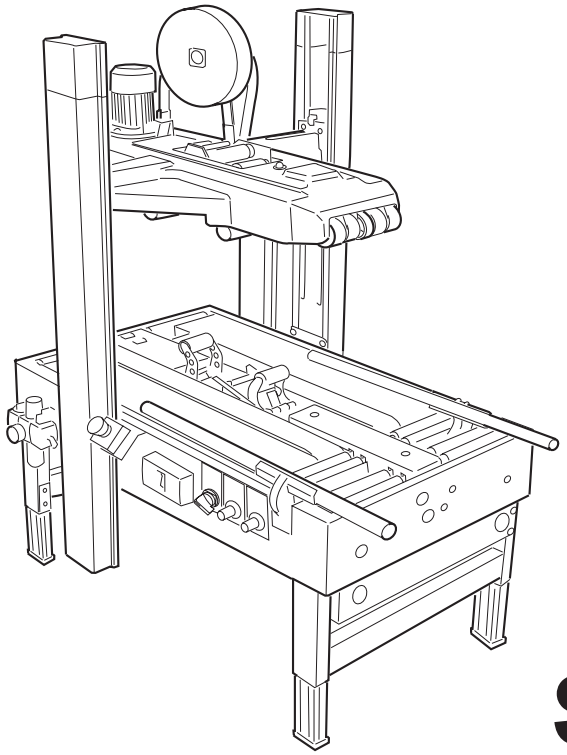
Publicación no. SMB00049K
Revisión ***I***



SR46-S Tipo **A**

PRECINTADORA AUTOMÁTICA AUTO-REGULADORA CON CORREAS DE ARRASTRE SUPERIORES E INFERIORES

-Dimensión máxima de la caja: h. 750 mm X w. 650 mm
-Cinta adhesiva de 75 mm
-Velocidad de avance de la caja: 22 m./minuto
-Producción media: 650 cajas/hora

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ABREVIACIONES Y SIGLAS

TABLAS DE LAS ABREVIACIONES SIGLAS Y TÉRMINOS DE USO NO COMÚN UTILIZADOS EN EL MANUAL

An.	=	Anexo
Dib.	=	Dibujo
Ej.	=	Ejemplo
Fig.	=	Figura de recambio
Máx.	=	Máximo
Mín.	=	Mínimo
Mod.	=	Modelo de la máquina
N.	=	Número
N/A	=	No se aplica (Not Applicable)
OFF	=	Máquina parada
ON	=	Máquina en movimiento
OPP	=	Polipropileno orientado
PLC	=	Programmable Logic Control (Equipamiento de control lógico programable)
PP	=	Polipropileno
PTFE	=	Politetrafluoroetileno
PVC	=	Polivinilcloruro
Ref.	=	Referencia
SIAT S.A.	=	Sociedad Internacional de Aplicaciones Técnicas (Sociedad Anónima)
Lám.	=	Lámina
w	=	Anchura
h	=	Altura
l	=	Longitud
ol	=	Longitud total
cbh	=	Altura superficie de trabajo

1-INTRODUCCION

1.1 NORMAS DE CONSTRUCCIÓN

La enfardadora semiautomática móvil SR4-S ha sido proyectada y construida respondiendo a los requisitos exigidos por la legislación vigente en la fecha de construcción.
LOS DOCUMENTOS DE REFERENCIA SON:
Directiva 98/37/CEE Directiva que concierne al acercamiento de las legislaciones de los Estados miembros relativas a las máquinas.
Directiva 89/336/CEE Directiva que concierne al acercamiento de las legislaciones de los Estados miembros relativas a la compatibilidad electromagnética.
Directiva 73/23/CEE Directiva que concierne al acercamiento de las legislaciones de los Estados miembros relativas al material eléctrico destinado a ser utilizado en ciertos límites de tensión.
UNI EN 292-1 Seguridad de la maquinaria - Conceptos fundamentales, principios generales de un proyecto - Terminología, metodología de base.
UNI EN 292-2 Seguridad de la maquinaria - Conceptos fundamentales, principios generales de un proyecto - Especificaciones y principios técnicos.
UNI EN 294 Seguridad de la maquinaria. Distancia de seguridad para impedir al acceso a zonas peligrosas para los miembros superiores.
UNI EN 349 Seguridad de la maquinaria. Espacios mínimos para evitar el aplastamiento de una parte del cuerpo.
UNI EN 418 Seguridad de la maquinaria. Dispositivos de parada de emergencia, aspectos funcionales. Principios de proyectación.
UNI EN 457 Seguridad de la maquinaria - Señales acústicas de peligro - Requisitos generales, proyectos y pruebas.
UNI EN 954 Seguridad de la maquinaria - Partes de los sistemas de mando relacionados con la seguridad - Principios generales de un proyecto.
UNI EN 1050 Seguridad de la maquinaria - Principios de valoración del riesgo.
CEI EN 60240 - 1 Seguridad de la maquinaria - Equipación eléctrica de máquinas - Parte 1: Reglas generales.

1.2 CÓMO LEER Y UTILIZAR EL MANUAL DE INSTRUCIONES

1.21. MPORTANCIA DEL MANUAL

El manual es una parte integrante de la máquina. Las informaciones contenidas en él les ayudarán a mantener su máquina en perfectas condiciones y a trabajar con plena seguridad.
Conserve el manual durante toda la vida del producto. Asegúrese de que cualquier enmienda realizada haya sido incorporada en el texto.
Pase el manual a cualquier usuario o propietario sucesivo de la máquina. Los esquemas de conexión y neumáticos se hallan normalmente en los anexos del manual. Para las máquinas más complejas, dotadas de PLC, o de una electrónica sofisticada, los diagramas se pueden encontar adheridos al cuadro de mandos o se pueden entregar a parte.

1.2.2 CONSERVACIÓN DEL MANUAL

Conservar el manual en un lugar protegido de la humedad y del calor.
No arrancar o reescribir por ningún motivo partes del manual.
Usar el manual sin dañarlo.
En caso de pérdida o daño, solicite una copia al propio servicio de asistencia/recambios, citando el código del documento.

1.2.3 CONSULTA DEL MANUAL

El manual está compuesto de:
- Páginas de identificación del documento y de la máquina;
- Indice analítico por argumentos;
- Instrucciones y notas sobre la máquina cap, 2÷4;
- Anexos, disenos y esquemas: cap. 15÷16;
- Recambios; al final del manual.

Todas las páginas y las tablas están numeradas, y las tablas de recambio están identificadas mediante el número de la figura.
Todas las indicaciones sobre la seguridad y sus posibles riesgos están identificadas por el símbolo:

Todas las indicaciones o notas de advertencia importantes para el funcionamiento de la máquina están identificadas por el símbolo

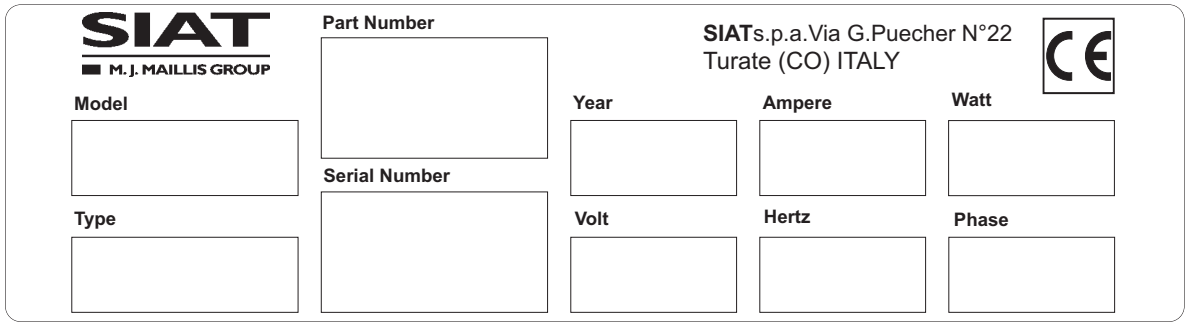
Las partes evidenciadas en **negrita** contienen referencias particulares a características técnicas específicas para el argumento en cuestión.

1.2.4 METODOLOGIA DE ACTUALIZACION DEL MANUAL EN CASO DE MODIFICACIONES EN LA MAQUINA

Las modificaciones en la máquina están reguladas por un específico procedimiento interno del constructor.
El usuario recibe el manual completo y puesto al día junto a la máquina, y puede recibir páginas o parte del manual que contenga correcciones sucesivas a la primera publicación, que deberán ser integradas en el manual bajo la responsabilidad del usuario.

2-INFORMACIONE GENERALES

2.1 DATOS DE IDENTIFICACIÓN DEL CONSTRUCTOR Y DE LA MÁQUINA



2.2 PARA LA ASISTENCIA TÉCNICA Y LOS RECAMBIOS, DIRÍJASE A:

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M. J. MAILLIS GROUP

Via Puecher, 22
22078 TURATE (CO) - ITALY

Tel. 02-964951
Fax. 02-9682239
E-mail siat@siat.com

AGENTE DISTRIBUDOR O SERVICIO ASISTENCIA TECNICA LOCAL:

2.3 GARANTÍA

En los límites de cuanto se indica a continuación, el proveedor se compromete a reparar todos los eventuales defectos de construcción que se manifiesten duran los seis meses de garantía a partir de la puesta en servicio de la máquina, pero, de cualquier manera, no más tarde de ocho meses después de la fecha de expedición.
Están expresamente excluidas aquellas piezas para las que está previsto un consumo normal, como correas, rodillo de goma, guarniciones, escobillas, etc., además de la parte eléctrica

.

Para disfrutar de la garantía, el cliente debe notificar inmediatamente al proveedor los defectos que se manifiesten, indicando el número de matrícula de la máquina. El cliente tiene que enviar al proveedor la pieza defectuosa para su reproducción y sustitución. El proveedor llevará a cabo la reparación en un período de tiempo razonable.

Con esta reparación o sustitución, el proveedor cumple plenamente con las propias obligaciones que derivan de la garantía. En el caso de que las reparaciones o sustituciones deban llevarse a cabo en el lugar en el que la máquina se halla instalada, el viaje y la estancia de los técnicos o montadores correrán completamente a cargo del cliente.
El proveedor no es responsable de los defectos que deriven de:

- Uso inadecuado de la máquina.
- Falta de manutención.
- Manipulaciones o reparaciones llevadas a cabo por el cliente.

Además el proveedor no será responsable de eventuales daños a personas o cosas diferentes de la máquina objeto de la presente garantía, ni de una eventual carencia de producción.

Para los materiales no construidos por el proveedor, como equipamientos eléctricos y motores, éste concede al cliente la misma garantía que él recibe por parte de los proveedores de dichos materiales.

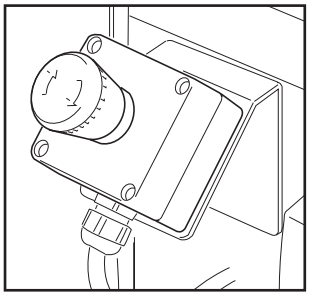
El proveedor no garantiza la adecuación de las máquinas a las disposiciones legales vigentes en los países extracomunitarios en los que se instalen y, en particular, a las relativas a accidentes y a la contaminación.

La adecuación de las máquinas a susodichas normas corre a cargo del cliente, el cual asume toda la responsabilidad, dejando indemne al proveedor y comprometiéndose a eximirlo de cualquier responsabilidad frente a cualquier tipo de reclamación por parte de terceros por efecto del incumplimiento de las mismas normas.

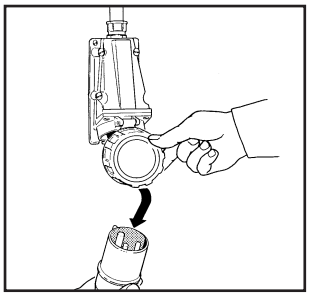
3-SEGURIDAD

3.1 ADVERTENCIAS GENERALES

Lea atentamente todas las instrucciones antes de utilizar la máquina; preste particular atención a las secciones donde se encuentra este símbolo



La precintadora Mod. SR46-S dispone de un pulsador STOP EMERGENCIA de retención situado cara operador de la máquina.
Si se utiliza se detiene la máquina en cualquier punto del ciclo sin desactivar el equipo pneumático.



Desconecte el enchufe de alimentación de la toma de corriente antes de cada operción de manutención.

.

Conserve este manual de instrucciones, las informaciones que contiene le ayudará a mantener su máquina en perfectas condiciones y a trabajar con plena seguridad.

3.2 DEFINICION DE LA ESPECIALIZACION DE LOS OPERADORES

- Operador de máquina.
- Técnico de manutención mecánica.
- Técnico de manutención eléctrica.
- Técnico especializado del fabricante.

El trabajo con la máquina solamente puede ser desarrollado por personas que posean las siguientes especializaciones.
El usuario tendrá la responsabilidad de establecer las personas especializadas en los varios niveles de intervención y procurar a las mismas un adiestramiento idóneo y las consignas operativas, tal y como se definen en este manual.

ESPECIALIDAD 1

OPERADOR DE MÁQUINA
Operador adiestrado y capacitado para el manejo de la máquina a través del uso del interruptor general y del STOP de emergencia, introducción de la caja, regulación de las dimensiones de la máquina en la caja, cambio de la cinta, arranque, parada y reactivación de la producción.
NOTA: los responsables del departamento prestarán gran atención al hecho de que el operador haya sido adiestrado en todas las operaciones antes de empezar a trabajar con la máquina.

ESPECIALIDAD 2

TÉCNICO DE MANUTENCIÓN MECÁNICA
Técnico especializado capaz de manejar la máquina como el operador y además de hacerla funcionar con los sistemas de seguridad desactivados, de intervenir en los órganos mecánicos para regularlos, llevar a cabo su manutención y reparación.
No es capaz de intervenir en instalaciones que contengan tensión eléctrica.

ESPECIALIDAD 2a

TÉCNICO DE MANUTENCIÓN ELÉCTRICA
Técnico especializado capaz de manejar la máquina como el operador y además de hacerla funcionar con los sistemas de seguridad desactivados, de intervenir en las regulaciones y en las instalaciones eléctricas, llevar a cabo su manutención y reparación.
Trabaja en presencia de tensión, en el interior de los cuadros eléctricos y cajas de derivación, aparatos de control etc.

ESPECIALIDAD 3

TÉCNICO ESPECIALIZADO DEL FABRICANTE
Técnico cualificado del constructor o de su representante para operaciones complejas, cuando se ha establecido un acuerdo con el usuario.

3.3 ADVERTENCIAS PARA INTERVENIR DE MODO SEGURO EN LA MAQUINA

El trabajo con la máquina puede ser llevado a cabo sólo por personas que posean las cualificaciones necesarias definidas en el párrafo 3.6
El usuario tendrá la responsabilidad de establecer las personas especializadas en los varios niveles de intervención y procurar a las mismas un adiestramiento idóneo y las consignas operativas, tal y como se definen en este manual.

3.4 ESTADOS DE LA MAQUINA

Enumeración de los posibles estados de esta máquina:
- Marcha automática,
- Marcha con protecciones reducidas,
- Parada con interruptor general
- Parada con el botón de emergencia retenido,
- Conexión eléctrica desactivada.
- Conexión aire comprimido desconectada

3.5 NUMERO DE OPERADORES

Las operaciones descritas a continuación han sido analizadas por el fabricante; el número de los operadores indicado para cada una de ellas es el adecuado para desarollar la función a pleno rendimiento. Un número inferior o superior de operadores pondría en peligro la seguridad del personal involucrado.

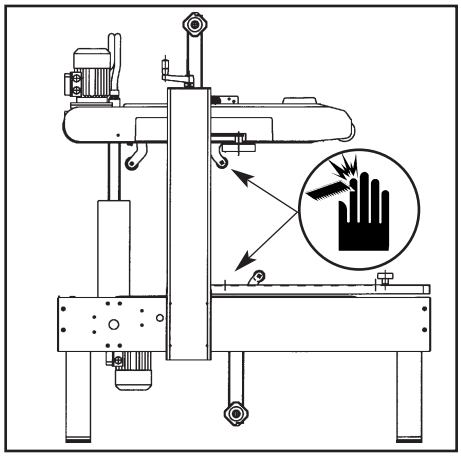
3.6 GRADO DE ESPECIALIZACION DE LOS OPERADORES

Se indica en cada operación la especialización mínima del operador.

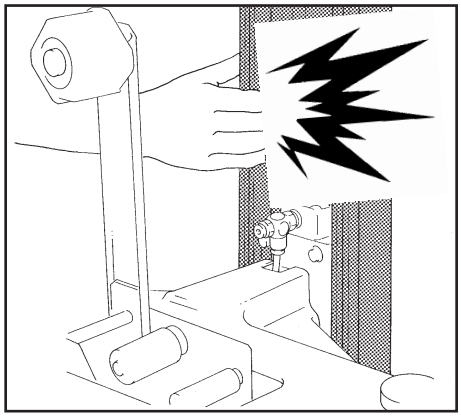
OPERACION	ESTADO DE LA MAQUINA	ESECIALIDA NUMERO	OPERADOR OPERADORES
Instalación y preparación para su utilización.	Marcha con protecciónes reducidas.	**2 e 2a**	2
Regulación de las dimensiones de la caja.	Parada con STOP de emergencia retenido.	**1**	1
Sustitución de la cinta.	Parada con STOP de emergencia retenido.	**1**	1
Sustitución de cuchillas.	Conexión eléctrica y pneumática desconectada	**2**	1
Sustitución de las bandas de arrastre.	Conexión eléctrica y pneumática desconectada	**2**	1
Manutención mecánica ordinria.	Conexión eléctrica y pneumática desconectada	**2**	1
Manutención eléctrica ordinaria.	Conexión eléctrica y pneumática desconectada	**2a**	1
Manutención mecánica extraordinaria.	Marcha con protecciónes reducidas.	**3**	1
Manutención eléctrica extraordinaria.	Marcha con protecciónes reducidas.	**3**	1

3.7 OTROS RIESGOS

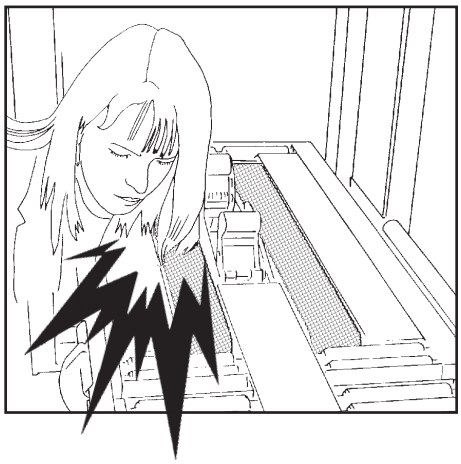
La precintadora SR46-S ha sido diseñada de acuerdo a la norma CE 392 con varios dispositivos y señales de seguridad, que nunca tienen que ser modificados o desactivados.
Teniendo en cuenta la precaucion adoptada por los proyectistas por la seguridad, es necesario que tanto el operador o tecnicos de mantenimiento esten informados previamente de los siguientes peligros residuales no eliminables.



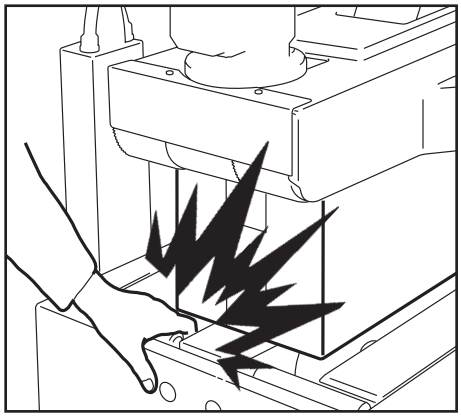
¡ATENCIÓN! Cuchilla de corte de la cinta.
No cambie el dispositivo de seguridad que cubre la cuchilla de corte de la unidad de cintaje superior e inferior.
Las cuchillas están extremadamente afiladas. Un error puede causar severas heridas.



¡ATENCIÓN! Columnas pneumáticas por deslizamiento.
Mantenga las manos lejos de la columna, peligro de aplastamiento

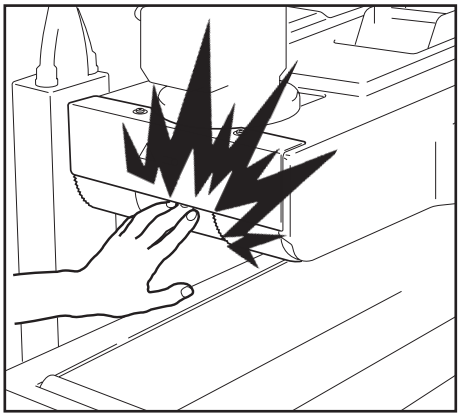


¡ATENCIÓN! Bandas de tracción superiores e inferiores.
No acerque nunca a la máquina cabellos o prendas como fulares, corbatas o mangas anchas. Aunque están protegidas, las bandas de tracción pueden ser peligrosas.



¡ATENCIÓN! Cavidad bajo el plano de deslizamiento a la salida de la caja.
No introduzca nunca las manos dentro de la máquina en movimiento. Peligro de aplastamiento.

¡ATENCIÓN! Correas superiores de arrastre.
No acompañe nunca con las manos el movimiento de las correas de arrastre.
Peligro de aplastamiento.



3.8 RECOMENDACIONES Y MEDIDAS DE PREVENCION CONTRA OTROS RIESGOS QUE NO PUEDEN SER DESATENDIDAS

El operador es invitado a permanecer en la posición de trabajo indicada en el parrafo. 12.1, a no tocar nunca las correas en movimiento, a no tocar ningún punto del interior de la máquina en funcionamiento, a no introducir las manos en ninguna cavidad, a alimentar la máquina teniendo las manos en la posición justa (ver parrafo 4.9), y a prestar mucha atención a las cuchillas mediante el cambio de cintas.

3.9 MEDIOS PERSONALES DE PROTECCIÓN

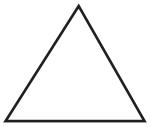
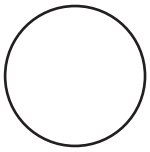
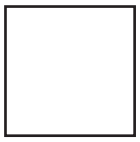
(Gafas, guantes, casco, zapatos, filtros/respiradores, auriculares de protección). Ninguno si no está recomendado por el usuario.

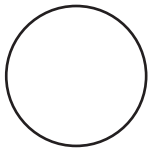
3.10 PROHIBICIONES RELATIVAS A COMPORTAMIENTOS NO CONSENTIDOS O INCORRECTOS, RAZONABLEMENTE PREVISIBLES

- No intente nunca contrarrestar la acción de tracción de la caja sin haber pulsado anteriormente el botón STOP EMERGENCIA.
- No utilice la máquina con las protecciones desmontadas.
- No desmontar las protecciones.
- Sólo el personal autorizado tendrá la facultad de efectuar las regulaciones, reparaciones y manutenciones que exige el manejo de la máquina con las protecciones reducidas.
- Durante tales operaciones el acceso a la máquina estará restringido a los técnicos especialistas.

- Las operaciones de limpieza y manutención deben realizarse después de haber cortado la energía eléctrica
.
- No modifique la máquina o partes de la máquina. La SIAT no responde de las posibles consecuencias.
- Le aconsejamos que solicite las eventuales modificaciones a la SIAT S.A.
- Limpie con trapos secos o soluciones detergentes suaves. No utilice disolventes, gasolina, etc.
- No modificar la máquina o partes de la misma. Siat no responde de las consecuencias.
- Aconsejamos solicitar a Siat S.p.A. las posibles modificaciones necesarias.
- Seguir atentamente las instrucciones de nstalación descritas en este manual; en caso contrario Siat S.p.A. no responde de los inconvenientes causados.

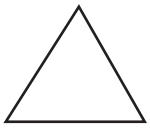
3.11 RESUMEN DE LAS ADVERTENCIAS, ETIQUETAS, PLACAS, DIBUJOS QUE APARECEN EN LA MAQUINA

	LEYENDA SÍMBOLOS	LEYENDA COLORES
	PELIGRO Y PARTES EN MOVIMIENTO	COLOR AMARILLO
	OBLIGACIÓN/PROHIBICIÓN	COLOR ROJO
	MANDOS E INFORMACIONES	COLOR AZUL

a 

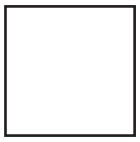
Indica que el final de carrera que regula la altura de la cabecera superior no tiene que ser desbloqueado en caso de falta de presión aire.

Codigo etiqueta: 3.0.010604.96/A

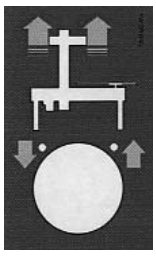
b 

Avisa al operador para que no toque la palanca que acciona la válvula para la subida de la cabecera superior.

Codigo etiqueta: 3.0.01029.96A

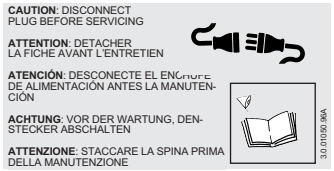
c 

Indica el selector de subida/bajada de la cabecera que facilita la extracción de la unidad precintadora inferior.



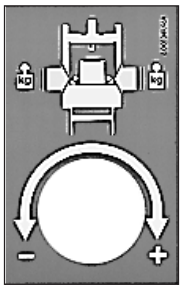
Codigo etiqueta: 3.0.01047.96A

d Indica que es obligatorio extraer el enchufe de la toma de alimentación antes de empezar cualquier operación de mantenimiento.


CAUTION: DISCONNECT PLUG BEFORE SERVICING
ATTENTION: DETACHER LA FICHE AVANT L'ENTRETIEN
ATENCIÓN: DESCONECTE EL ENCHUFE DE ALIMENTACIÓN ANTES LA MANUTENCIÓN
ACHTUNG: VOR DER WARTUNG, DEN-STECKER ABSCHALTEN
ATTENZIONE: STACCARE LA SPINA PRIMA DELLA MANUTENZIONE
3.0.01050.96A

Codigo etiqueta: 3.0.01050.96A

e Indica el botón para el registro de la presión de las guías laterales en la caja.



Codigo etiqueta: 3.0.01049.96A

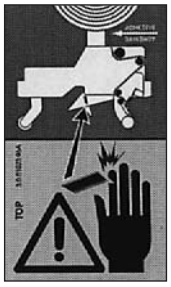
f Indica el botón para el registro del peso de la cabecera en la caja.

Codigo etiqueta: 3.0.01048.96A

g Indica peligro de cuchilla cortante de la unida precintadora.

Codigo etiqueta: 3.0.01028.96A

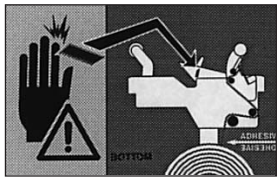
h Indica el recorrido de la cinta de la unidad precintadora superior y peligro de cuchilla cortante.



Codigo etiqueta: 3.0.01023.96A

i

Indica el recorrido de la cinta de la unidad precintadora inferior y peligro de cuchilla cortante.



Codigo etiqueta: 3.0.01024.96A

l

Indica la dirección de marcha de las correas de arrastre.

Codigo etiqueta: 3.0.01040.96A

m

Indica la presencia de aire en el circuito (indicador rojo visible).

Codigo etiqueta: 3.0.01035.96A

n

Avisa al operador para que no toque la tapa que acciona las válvulas para el cierre/apertura de las guías laterales de la caja.

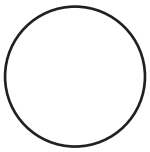
Codigo etiqueta: 3.0.01027.96A

o

Avisa al operador a prestar atención para no introducir nada en las cavidades de las guías laterales de la caja.

Codigo etiqueta: 3.0.01036.96A

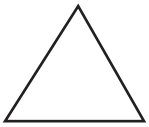
p



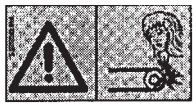
Avisa al operador para que no toque las columnas en el interior de las cuales está situado el cilindro para la subida de la cabecera superior.

Codigo etiqueta: 3.0.01041.96A

q

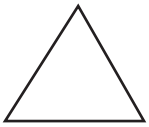


Indica el peligro de las correas de arrastre superior en movimiento.



Codigo etiqueta: 3.0.01030.96A

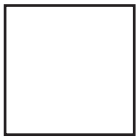
r



Indica el peligro de las correas de arrastre inferior en movimiento.

Codigo etiqueta: 3.0.01031.96A

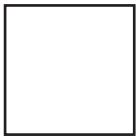
s



Indica los mandos de marcha/parada y evidencia que en el interior de la caja del interruptor magnetotérmico circula corriente eléctrica.

Codigo etiqueta: 3.0.01090.96A

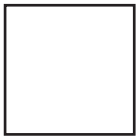
t



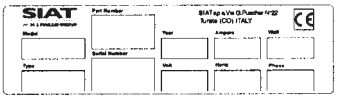
Indica el punto en el que el cable de protección está conectado al cuerpo de la máquina (puesta a tierra).

Codigo etiqueta: 3.0.01039.96A

u



Contiene los datos de identificación del modelo, número de matrícula y fabricante de la máquina.



Codigo etiqueta: SBC0000629

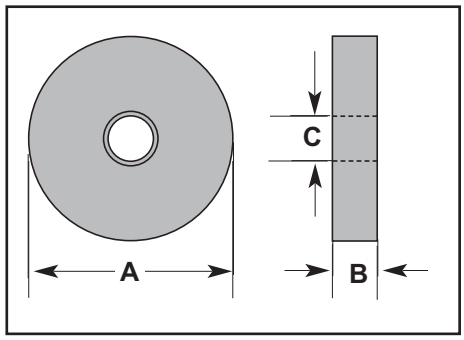
4-INFORMACIONES PRELIMINARES SOBRE LA MAQUINA

4.1 DESCRIPCION GENERAL SR46-S

Precintadora automática con bandas de arrastre superiores e inferiores autoregulable, idónea para precintar cajas de dimensiones variadas.

4.2 DATOS TECNICOS

- Producción media = 650 cajas/hora
- Alimentación estándar = 230/400V 50Hz 3Ph
- Dos motores (HP 0,18) kW 0,12
- Unidades precintadoras K12, anchura de la cinta 75mm
- Peso = 165 kg
- Velocidad de correas = 22 m/minuto
- Aire comprimido máx. 6 Bar.



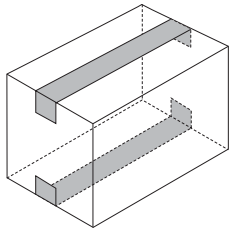
4.3 DIMENSIONES DE LA CINTA

Cintas adhesivas adecuadas:
PVC
OPP
PAPEL ADHESIVO

A = 410 mm max
B = 75 mm
C = 76 mm

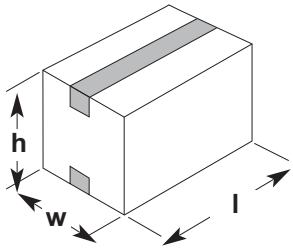
4.4 USO PREVISTO

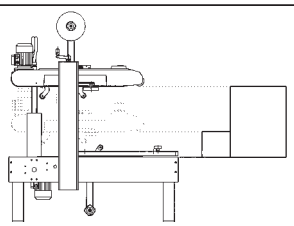
El Precintado con cinta adhesiva de cajas con las dimensiones (en milímetros) indicadas en 4.5 aplicando a la vez dos tiras de cinta adhesiva (una en la parte superior y otra en la parte inferior de la caja).
La máquina con la instalación eléctrica estándar no es adecuada para su empleo en ambientes con riesgo de explosión, donde se necesitan componentes a prueba de explosión y/o motores de aire.



4.5 DIMENSIONS DE LAS CAJAS

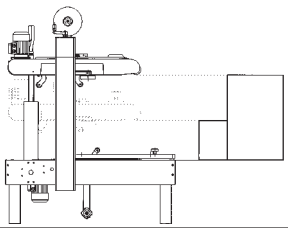
La precintadora SR46-S se regula automáticamente para precintar las cajas cuyas medidas tenemos indicadas en la (apartado 1).
Para el precintado de cajas de altura mas alla de 750 mm. se desplaza la fijacion de las columnas, tal como de indica en el (apartado 2)





1 COLUMNAS FIJAS EN POSICIÓN BAJA

MEDIDAS DE LA CAJA		MIN	MAX
	L	**150**	
	W	**170**	**650**
	H	**130**	**750**



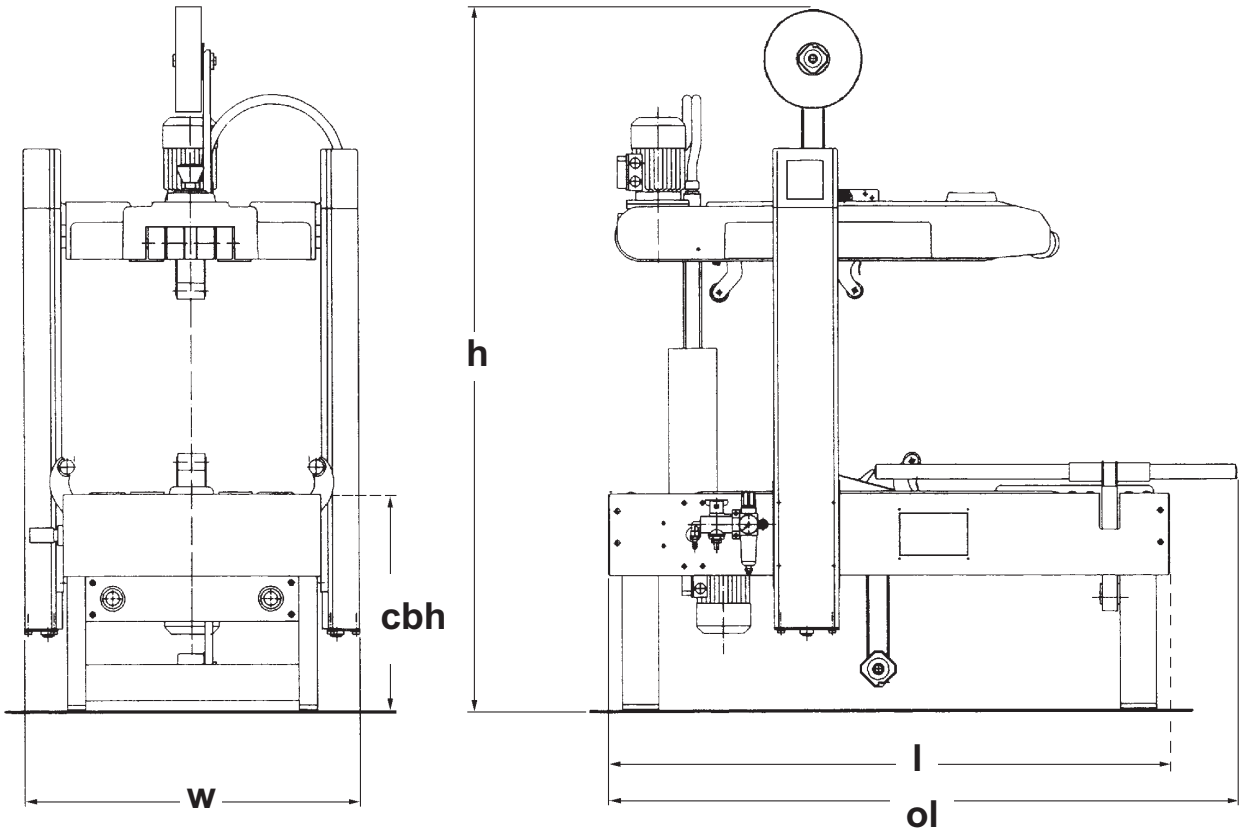
2 COLUMNAS FIJAS EN POSICIÓN ALTA

MEDIDAS DE LA CAJA			
	L	**150**	
	W	**170**	**650**
	H	**340**	**930**

NOTE

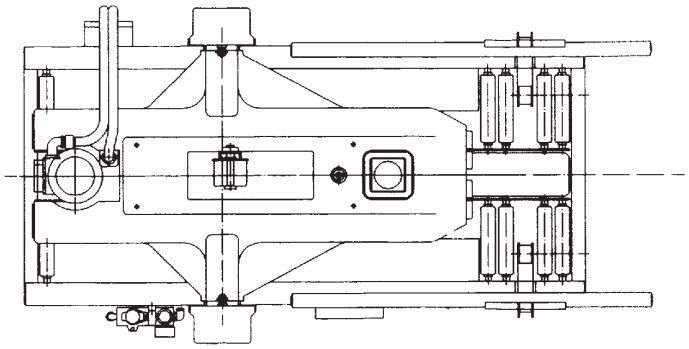
- La longitud de la caja se refiere a la medida en el sentido del precintado.
- Para cajas con una relación inferior es necesario efectuar una prueba para asegurarse del perfecto funcionamiento, que depende de varios factores como el peso y la rigidez de las cajas.
- En algunos casos, el fabricante puede realizar modificaciones especiales en la precintadora SR46-S para precintar cajas de formatos más pequeños o más grandes de los aquí indicados. En caso de interés dirigirse al servicio de Asistencia Técnica Siat.

4.6 DIMENSIONE TOTALES



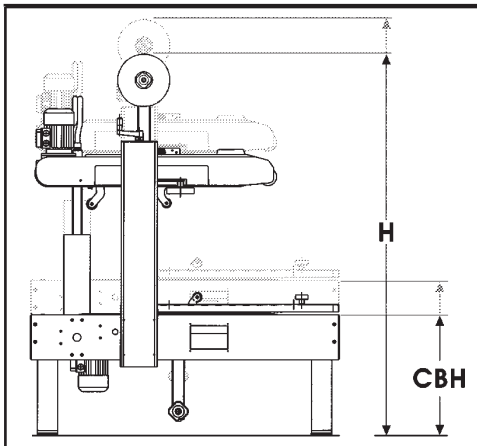
DIMENSIONES

l = longitud 1240 mm
w = anchura 940 mm
h = altura1275÷2025 mm
ol = longitud total, incluyendo las barras centradoras: 1390 mm.
cbh = altura superficie de trabajo: véase párrafo 4.7



4.7 ALTURA DEL PLANO DE RODILLOS

La precintadora SR46-S consiente un amplio margen de regulacion de la altura del plano de desplazamiento de la caja. Son varias las combinaciones que se pueden obtener con los accesorios obcionales AS77 (ruedas) y con AS80 (patas), tal como se indica en la pagina siguiente.

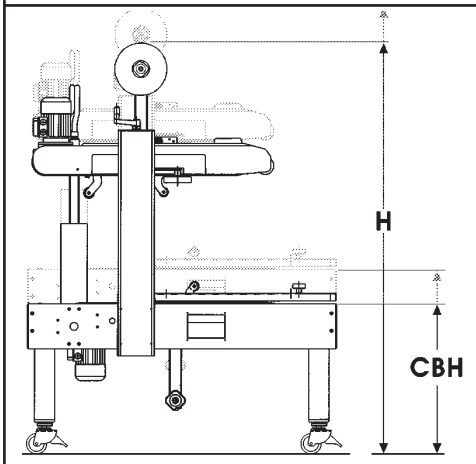


A CON PATAS ESTANDARD

ALTURA DEL PLANO DE RODILLOS	MIN	MAX
CBH	**485**	**825**

DIMENSIONES GENERALES

	MIN	MAX
H	**1275**	**2025**
L	**1240**	**1240**
W	**940**	**940**

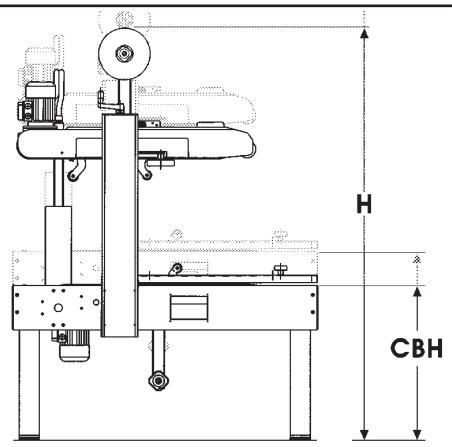


B CON RUEDAS AS77 (OPCIONALES)

ALTRA DEL PLANIO DE RODILLOS	MIN	MAX
CBH	**585**	**925**

DIMENSIONES GENERALES

	MIN	MAX
H	**1375**	**2125**
L	**1240**	**1240**
W	**940**	**940**

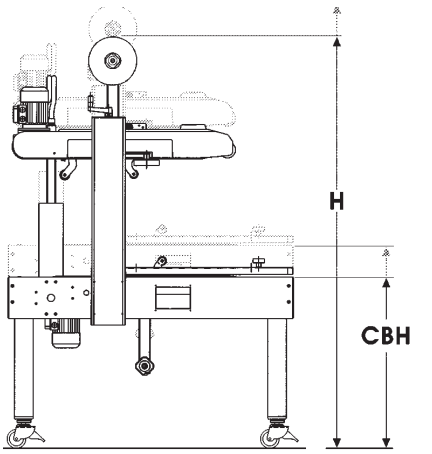


C CON PATAS AS80 (IOPCIONALES)

ALTURA DEL PLANO DE RODILLOS	MIN	MAX
CBH	**645**	**1135**

DIMENSIONES GENERALES

	MIN	MAX
H	**1435**	**2335**
L	**1240**	**1240**
W	**940**	**940**



D CON PATAS AS80 Y RUEDAS AS77 (OPCIONALES)

ALTURA DEL PLANO DE RODILLOS	MIN	MAX
CBH	**745**	**1235**

DIMENSIONES GENERALES

	MIN	MAX
H	**1535**	**2435**
L	**1240**	**1240**
W	**940**	**940**

4.8 COMPONENTES PRINCIPALES

La máquina está compuesta por:

N. 1 bancada
N. 4 patas regulables
N. 2 columnas
N. 2 unidades de precintado
N. 1 cabezal superior
N. 1 motorización superior
N. 1 motorización inferior
N. 2 motores eléctricos
N. 1 tecla STOP EMERGENCIA
N. 1 interruptor principal ON/OFF

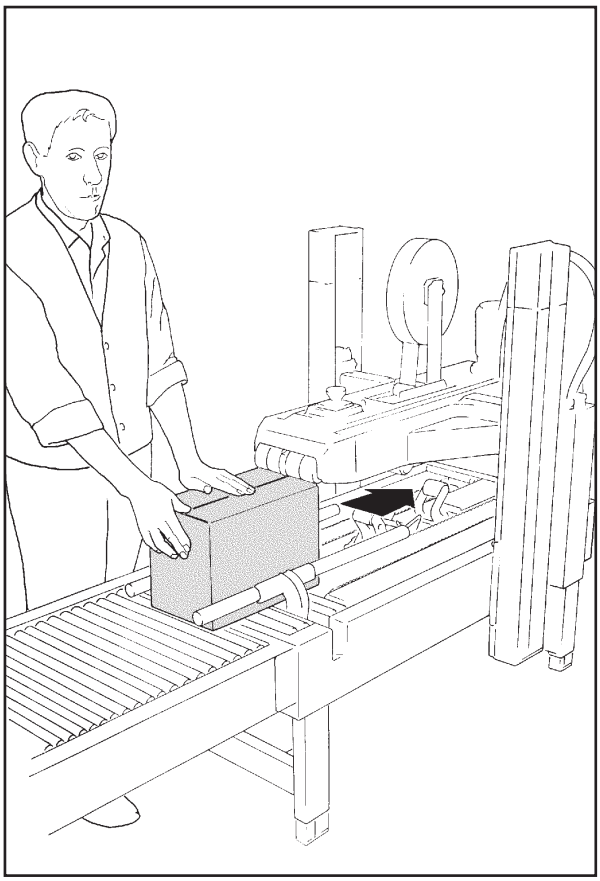
Para las características técnicas de los motores eléctricos, véase la sección 15 - ANEXOS.

4.9 FLUJO OPERATIVO

Una vez llena la caja, cierre las solapas superiores y empújela entre las bandas de arrastre superiores e inferiores.
Introducir la caja en la máquina hasta superar las correas de arrastre; la caja será arrastrada por las correas tan pronto como el grupo superior haya vuelto a bajar.

Tenga las manos siempre y solamente en la posición indicada en la Figura.

La caja se precinta después automáticamente con cinta adhesiva en el lado superior y en el inferior, y luego se expulsa por el rodillo de salida.



4.10 MEDICIÓN DEL NIVEL DE RUIDOS

Presión acústica detectada a una distancia de 1 metro de la máquina con la cinta adhesiva introducida: 73 dB.
Presión acústica a una altura de 1,6 metros de la máquina con cinta adhesiva introducida: 73 dB. Tomas realizadas con un instrumento tipo SPYRI-MICROPHON.

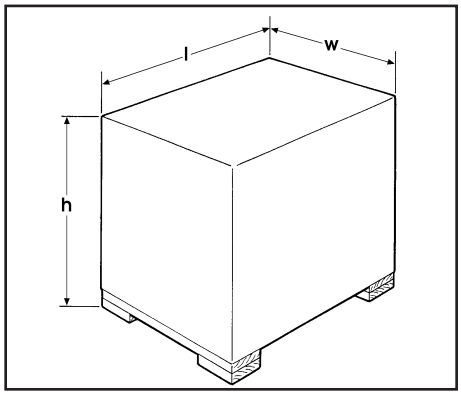
5-TRANSPORTE - MOVIMIENTO -ALMACENAMIENTO

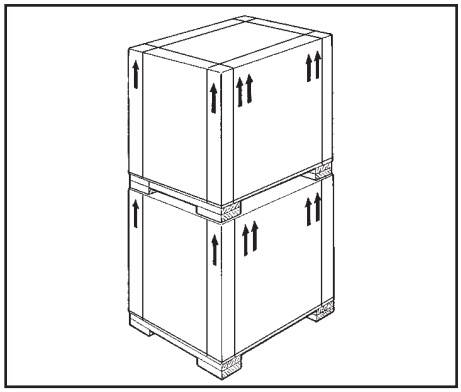
5.1 TRANSPORTE Y MOVIMIENTO DE LA MAQUINA EMBALADA

La máquina está fijada en la bancada mediante cuatro tornillos y puede ser elevada mediante una simple carretila elevadora de horquilla.
El embalaje estándar es el adecuado para viajar por vía terrestre y por vía aérea. El embalaje vía marítima, se hará a petición del cliente.

DIMENSION EMBALAJE

l = longitud 1400 mm
w = anchura 1000 mm
h = altura 1300 mm
Peso kg. 210

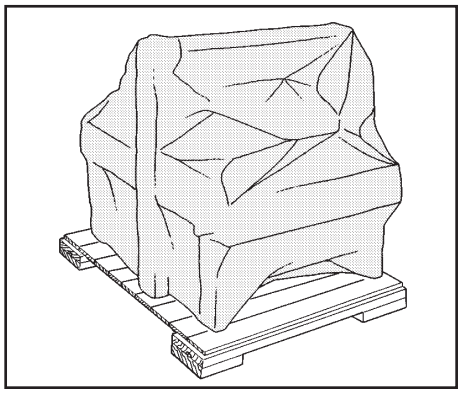




Durante la fase de transporte es posible sobreponer un máximo de dos máquinas.

5.2 EMBALAJE MARITIMO (OPTATIVO)

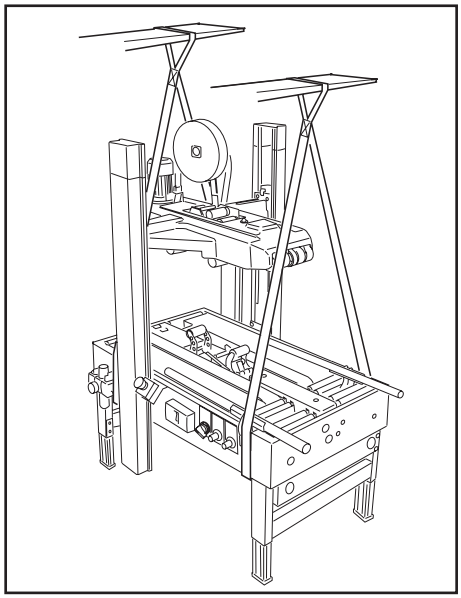
Las máquinas enviadas por vía marítima se envuelven en un saco de material acoplado aluminio/poliéster/politeno que contiene sales deshidratantes.



5.3 TRANSPORTE Y MOVIMIENTO DE LA MAQUINA DESEMBALADA

La máquina desembalada no tiene que ser transportada sino en distancias muy cortas y dentro de los departamentos. El transporte de la máquina sin el embalaje puede ocasionar desperfectos e infortunios. Si fuera necesario cambiar la posición de la máquina, izarla utilizando correas de levantamiento según se muestra en la Tabla y levantarla con la ayuda de una carretilla elevadora o una grúa.

DIMENSION DE LA MAQUINA
longitud 1240 mm
anchura 940 mm
altura 1275 mm min; 2025 mm max,
Peso kg. 165

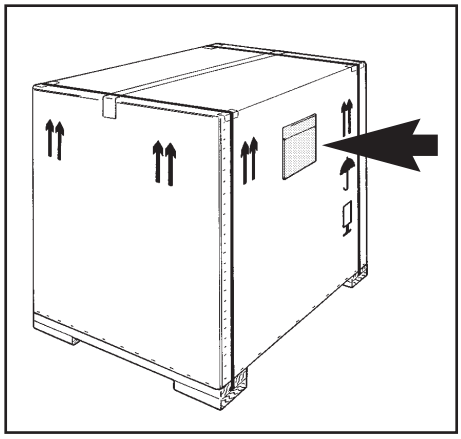


5.4 ALMACENAMIENTO DE LA MAQUINA EMBALADA O DESMBALADA

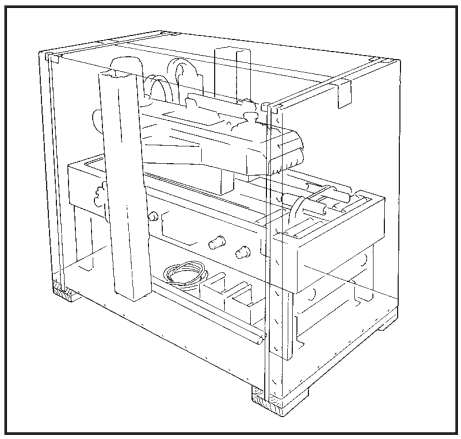
Precauciones por larga inactividad de la máquina:
- almacenar en un lugar seco y limpio;
- si la màquina está desembalada es necesario protegerla del polvo y no colocar nada encima;
- si las máquinas estám desembaladas se puden superponer dos como máximo.

6-DESEMBALAJE

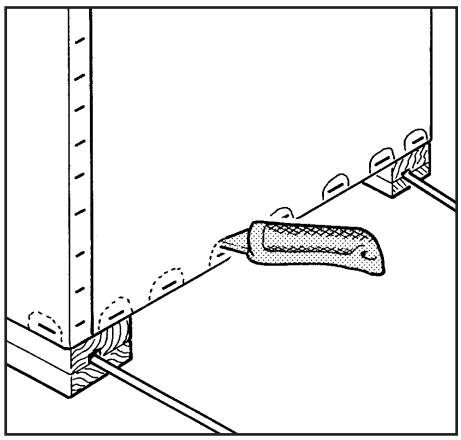
6.1 Sobre en el exterior del embalaje que contiene las instrucciones para el desembalaje de la maquina mod. SR46-S.



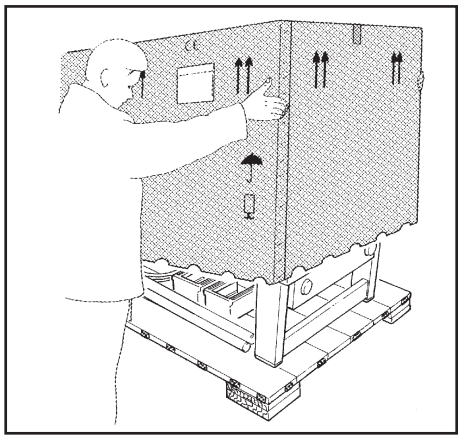
Posición de la máquina dentro del embalaje.



Cortar los flejes de polipropileno. Cortar con un "cuter" la parte del cartón fijada con las grapas a lo largo de todo el perímetro del embalaje (o bien, si se poseen los utensilios adecuados, se pueden quitar los puntos metálicos).

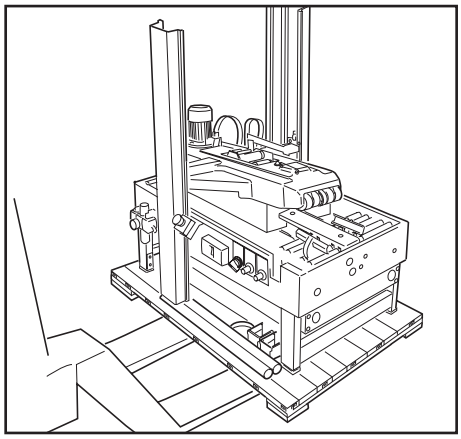


Después de haber cortado el cartón o después de quitar los puntos metálicos, sacar completamente el cartón de manera que la máquina quede libre (dos personas).

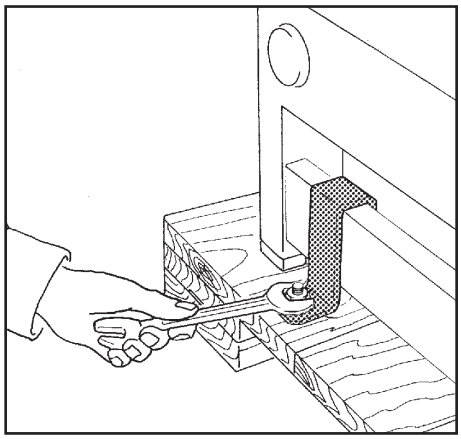


6-DESEMBALAJE

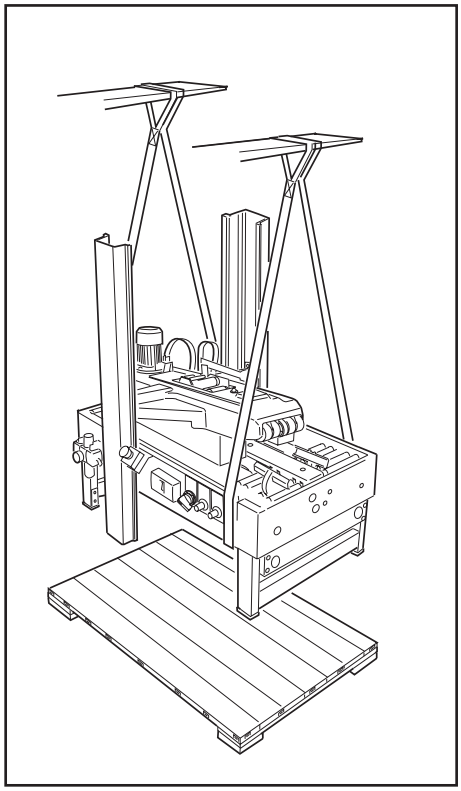
Transportar la máquina con una grúa elevadora hasta el punto en el que la misma quede colocada
(Peso de la máquina + Bancada = 185 kg).



Aflojar las tuercas y quitar, con la llave en dotación, las escuadras de bloqueo que fijan la máquina a la bancada.



Levantar la máquina según se indica en la Lámina (Peso de la máquina Kg. 165) y extraer el pallet.



6.2 ELIMINACION DEL EMBALAJE

El embalaje de la máquina Mod. SR46-S está compuesta por:
- bancada de madera;
- caja de cartón;
- soportes de madera;
- refuerzos de sujeción de acero;
- protección de espuma de politeno;
- flejes de plástico (PP);
- sales deshidratantes de arcilla;
- saco con material acoplado compuesto por poliéster-aluminio-politeno (sólo por vía marítima).

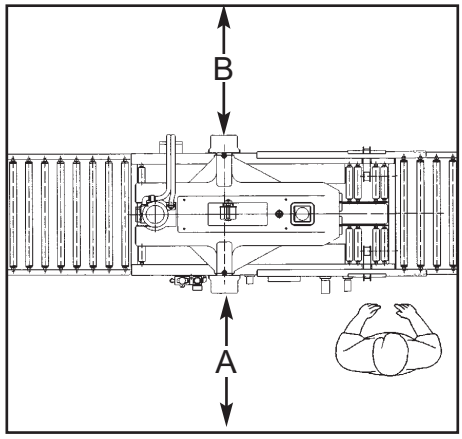
Para la eliminación del embalaje compórtese de acuerdo con las normas vigentes en su propio país.

7-INSTALACION

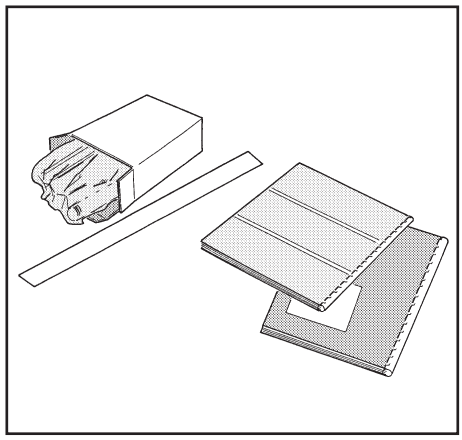
7.0 SEGURIDAD
(véase capítulo 3).

7.1 CONDICIONES AMBIENTALES
-Temperatura mín. = 5° C; Temperatura máx. = 40° C
Humedad mín. 30%; máx. 80%
- Ambiente protegido del polvo.

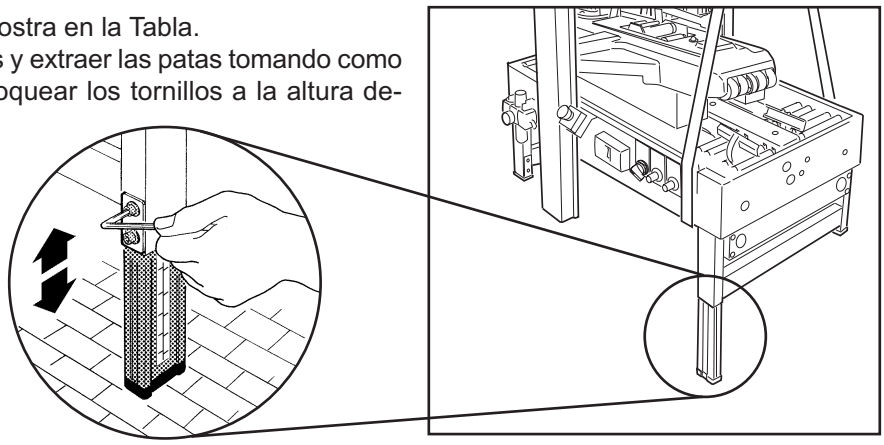
7.2 ESPACIO NECESARIO PARA EL USO Y LA MANUTENCION
Distancia mínima de la pared.
A = **1000** mm
B = **700** mm
Altura mín. = **2500** mm



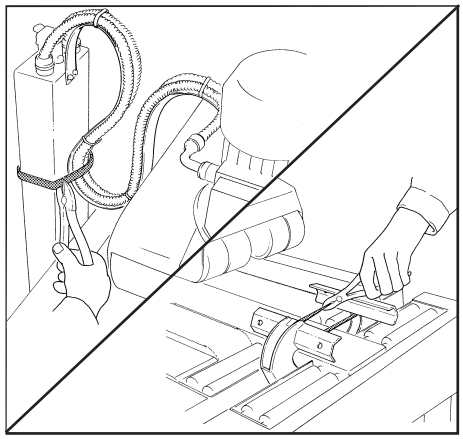
7.3 SET RECAMBIOS Y TIRACINTA PARA UNIDAD PRECINTADORA EN DOTACIÓN CON LA MÁQUINA
Para la descripción detallada de las herramientas véase la sección 13.1.



7.4 COLOCACION
Levantar la máquina según se muestra en la Tabla.
Desbloquear los tornillos marcados y extraer las patas tomando como referencia la escala graduada. Bloquear los tornillos a la altura deseada.

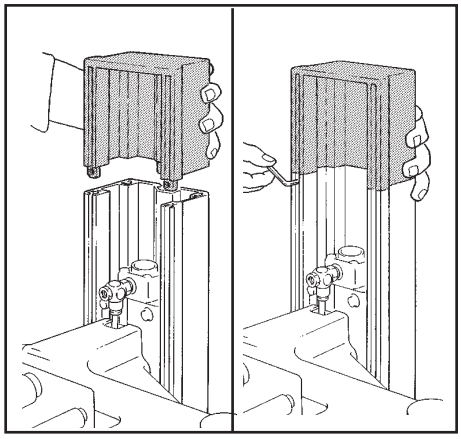


7.5 DESMONTAJE DE LOS ELEMENTOS DE BLOQUEO
Cortar la faja que bloquea el fleje al canal con los cables de alimentación del motor y parada de emergencia, así como la faja que bloquea las palancas del centrador.



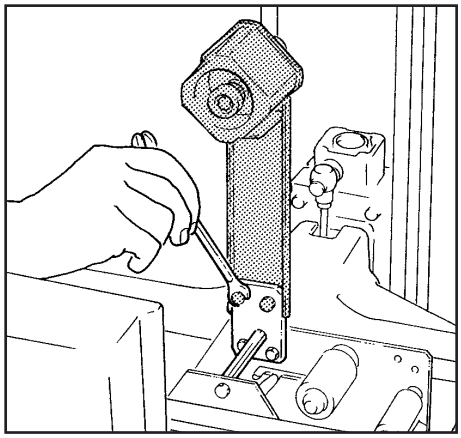
7.6 POSICIONAMIENTO PROTECCIONES COLUMNAS

Recuperar las protecciones columnas y montarlas según se muestra en la Tabla.



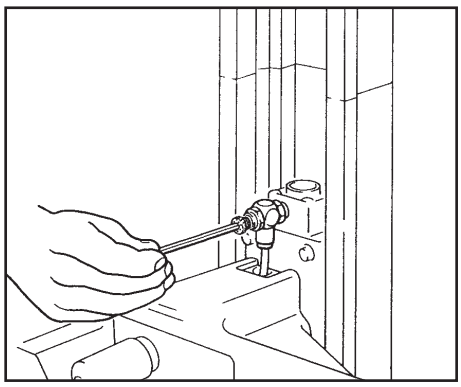
7.7 MONTAJE DEL SOPORTE PORTARROLLOS SUPERIOR

Quitar los tornillos que fijan el portabobina a la máquina, colocarlo según la Tabla y bloquearlo con los tornillos extraídos con anterioridad.

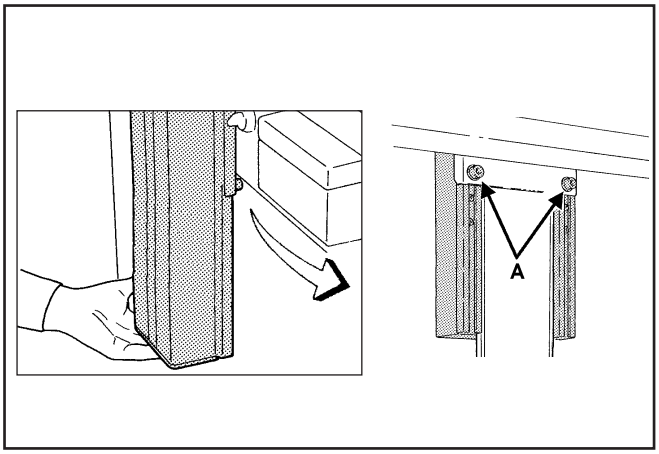


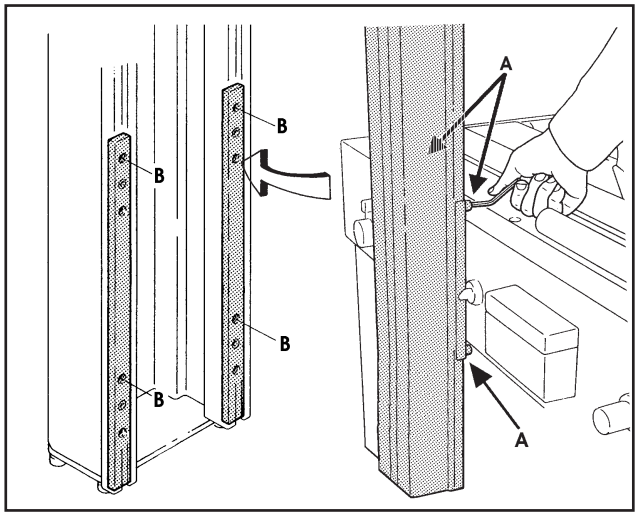
7.8 POSICIONAMIENTO COLUMNAS

Aflojar el tapón del cilindro pneumático.



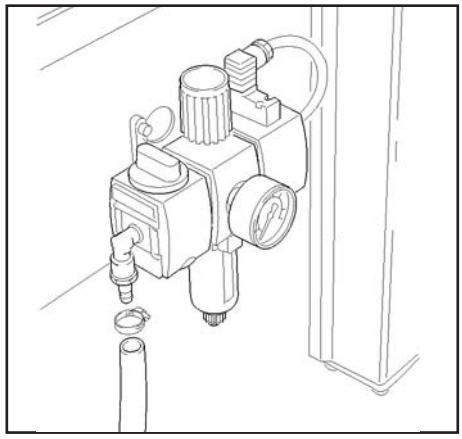
Sujetar con una mano la columna y quitar los dos tornillos **A**. Empujar hacia arriba la columna hasta colocarla en correspondencia con los orificios **B**.
Recuperar los otros dos tornillos de las piezas de recambio y fijar la columna. (cuatro tornillos por columna).



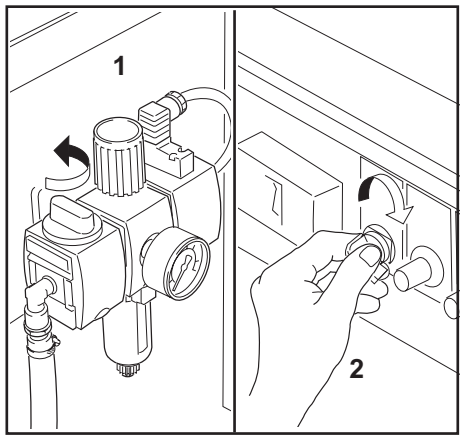


7.9 CONEXIÓN PNEUMÁTICO

Conectar un tubo de 8 mm. al empalme y fijarlo con la abrazadera que se da en dotación.

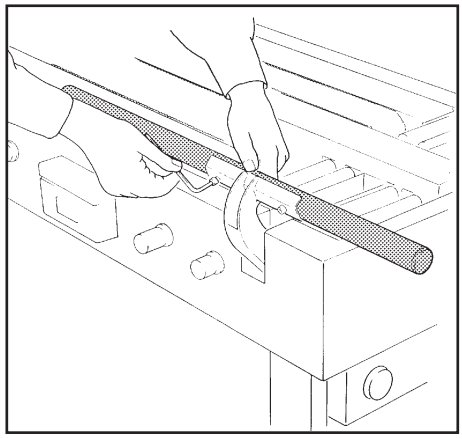


Poner en funcionamiento el equipo pneumático desde el mando 1 y levantar la cabecera superior con el selector 2. Quitar los bloqueos de poliestirol utilizados para el transporte.



7.10 POSICIONAMIENTO GUÍAS CAJA

Montar las guías caja en las palancas del centrador, según se ilustra en la Tabla.



7.11 CONTROLES ELECTRICOS PRELIMINARES

Antes de conectar la máquina a la toma de corriente, llevar a cabo las siguientes operaciones:

7.11.1 Asegúrese de que el enchufe posea un circuito de protección de tierra y de que la tensión y la frecuencia de alimentación correspondan a las indicadas a la etiqueta de la máquina.

7.11.2 Es responsabilidad del usuario comprobar que la conexión de la máquina a la red respete las normas en vigor en el país en el que se instala.

7.11.3 La máquina está dotada de un interruptor general con un poder de interrupción de 6kA y de un desenganchador de cortocircuito que interviene a 120 A.
El usuario tiene la responsabilidad de controlar la corriente del cortocircuito de su instalación y de verificar que la intensidad de la corriente prevista en los bornes del interruptor general sea compatible con la propia intalación.

7.12 CONEXION CON LAS FUENTES DE ENERGIA Y CONTROLES CORRESPODIENTES

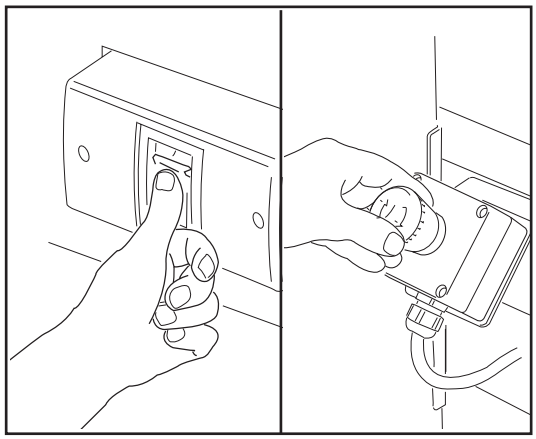
Potencia instalada = kW 0,240
Poder de interrupción del interruptor general = 6 kA (230/400V)
Para las características técnicas del interruptor general, véase la sección **15** - **ANEXOS**.

- Pulsar la tecla STOP EMERGENCIA de retención.
- El interruptor principal magnetotérmico se halla normalmente en la posición OFF.
- Conectar con el cable en dotación con la máquina un enchufe en conformidad con la normativa del país del usuario.

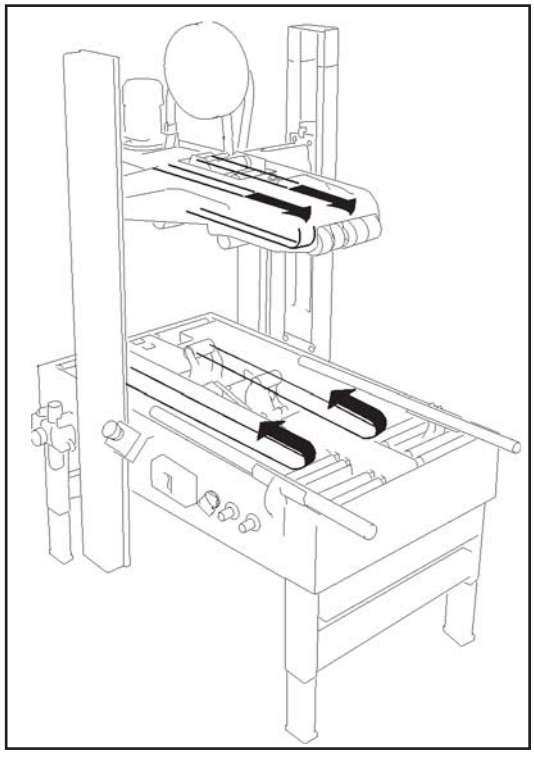
7.13 CONTROL DE LAS FASES (PARA ALIMENTACION TRIFASICA)

Procedimiento que es necesario seguir para una conexión adecuada del orden de las fases:

-Quitar las herramientas que hayan podido quedar apoyadas en la máquina.
-Desbloquear el pulsador stop de emergencia con retén, girándolo en sentido horario.
-Pulsar la tecla ON en el interruptor principal y comprobar.
-Antes de usar la máquina el sentido de rotación de las correas de arrastre.
-En el caso de que rotasen en sentido contrario, invertir dos fases en los bornes del enchufe de conexión.



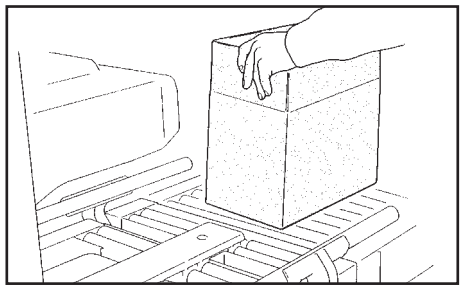
Sentido de rotación de las correas de arrastre.



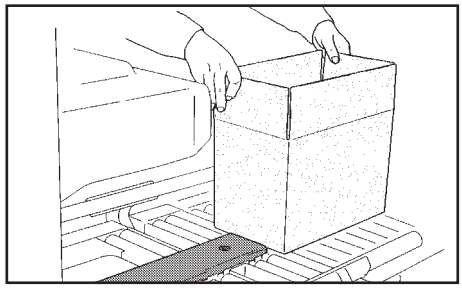
8-FUNCIONAMIENTO

8.1 DESCRIPCIÓN DEL FUNCIONAMIENTO

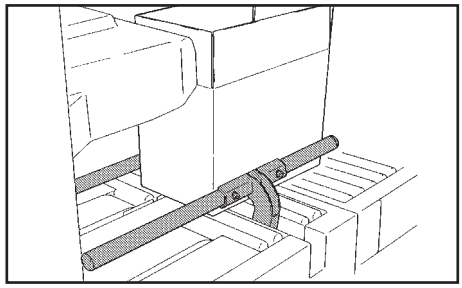
Doblar manualmente las cuatro solapas inferiores de la caja.
Apoyar la caja con las solapas inferiores dobladas sobre los rodillos.



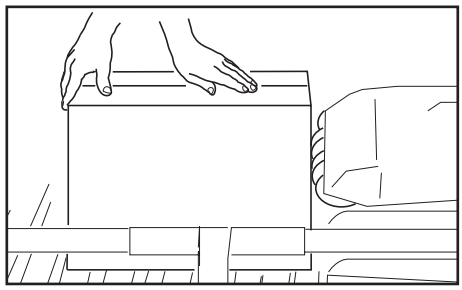
Sujetando la caja con las dos manos transportarla hasta hacer presión contra la válvula a palanca, ésta acercará las guías laterales a la caja



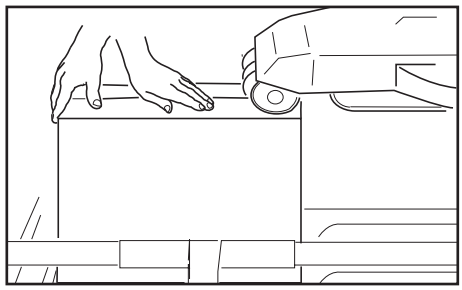
Las guías laterales bloquean la caja en el centrador permitiendo de esta forma llenarla sin tener que sujetarla con las manos.



Una vez llenada la caja, doblar las solapas superiores y empujar la caja contra la palanca que mandará la subida de la cabecera.



Empujar la caja hasta la máquina hasta llegar a las correas de arrastre inferiores.



8.2 DESCRIPCION DE LAS MODALIDADES DE MARCHA

La precintadora Mod. SR4-S trabaja sólo de modo automático:
- botón STOP EMERGENCIA no retenido;
- botón STOP EMERGENCIA no retenido;
- equipo pneumático activado.

8.3 DESCRIPCION DE LAS MODALIDADES DE PARADA

8.3.1 PARADA NORMAL

La parada de la máquina es inmediata en cualquier punto del ciclo si se sitúa el interruptor general en OFF.
El mismo efecto se obtiene con la interrupción de la alimentación de la red.
El equipo pneumático permanece activado.

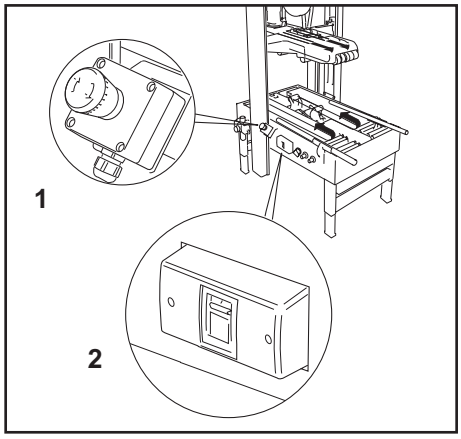
8.3.2 PARADA DE EMERGENCIA

Pulsante con forma de hongo para la parada de emergencia con retención.
(Componente en un lado de la máquina no fabricado por el constructor. Para sus características técnicas véase le sección **15 - ANEXOS**).

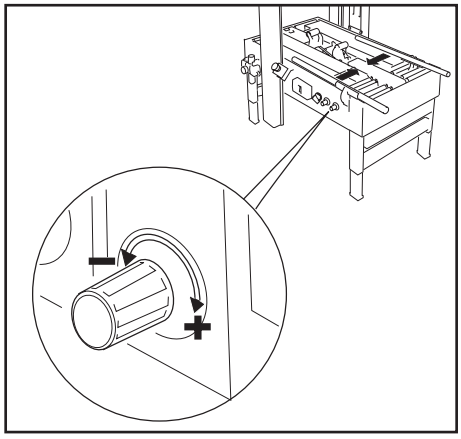
9-MANDOS

6.1 PULSADOR DE MARCHA/PARADA (1)
Pone en movimiento/detiene las correas de arrastre caja.

BOTÓN STOP DE EMERGENCIA (2)
Detiene el ciclo de la máquina.

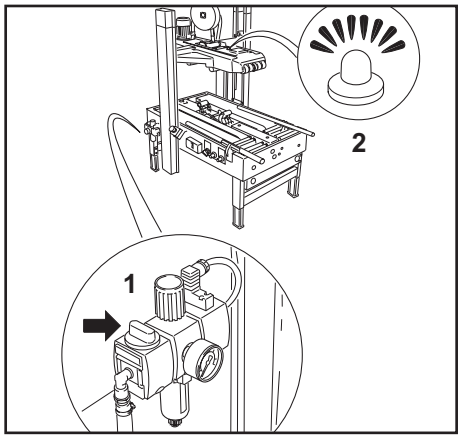


9.2 BOTÓN REGISTRO PRESIÓN GUÍAS
Regula la presión de las guías caja en la caja.

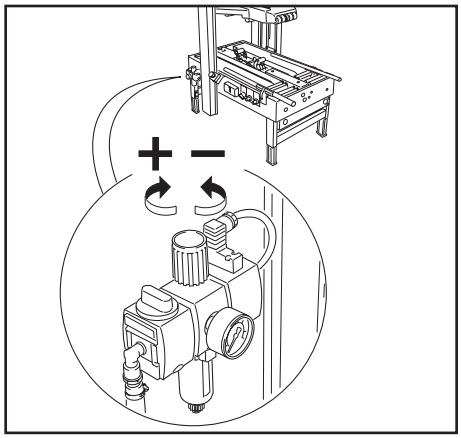


9.3 VÁLVULA ALIMENTACIÓN EQUIPO PNEUMÁTICO (1)
Activa/desactiva el equipo pneumático.

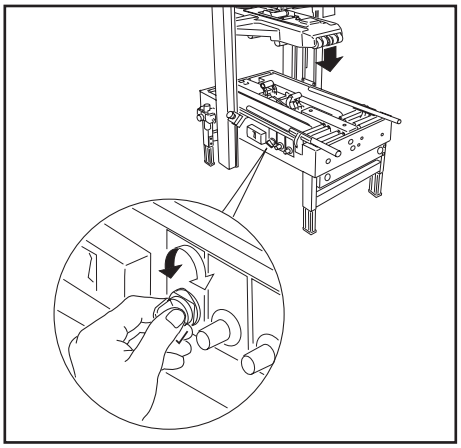
PILOTO PRESIÓN AIRE (2)
Indica la presencia de aire en el circuito (indicador rojo encendido).



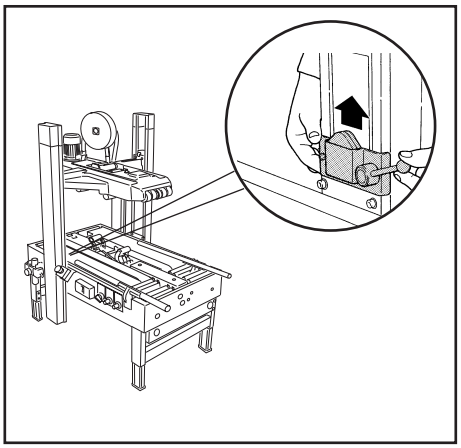
9.4 BOTÓN REGISTRO PRESIÓN EQUIPO PNEUMÁTICO
Aumenta/disminuye la presión en el circuito.



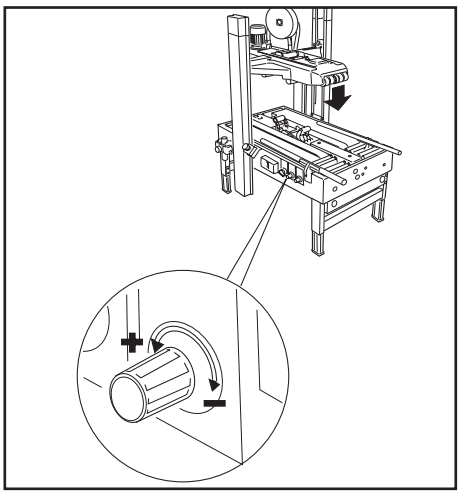
9.5 SELECTOR SUBIDA/BAJADA CABECERA.
Hace subir/bajar la cabecera superior.



9.6 BLOQUEO ALTURA CABECERA
Sirve para colocar la cabecera superior en función de las cajas más bajas.



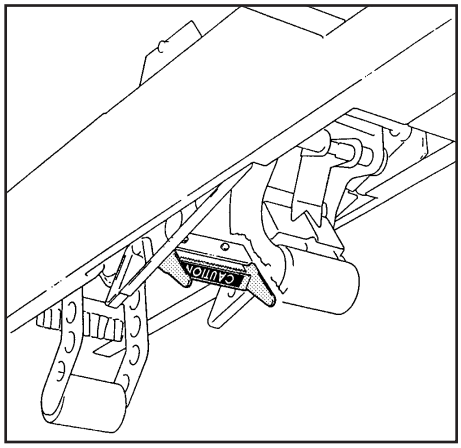
9.7 BOTÓN REGISTRO PRESIÓN CABECERA
Aumenta/disminuye la presión de la cabecera (bajada) en la caja.



10-DESCRIPCION DE LOS SISTEMAS DE SEGURIDAD DE LA MAQUINA

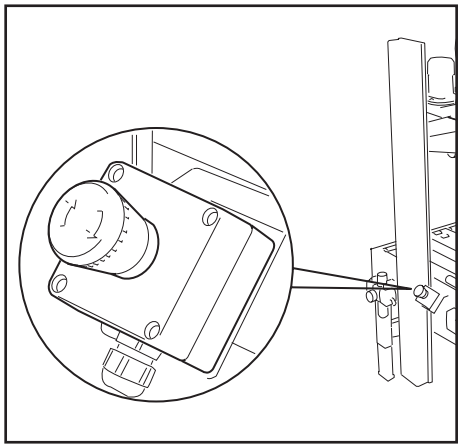
10.1 PROTECCION DE LAS CUCHILLAS

Las cuchillas de las dos unidades de precintado están protegidas por un dispositivo de muelle.



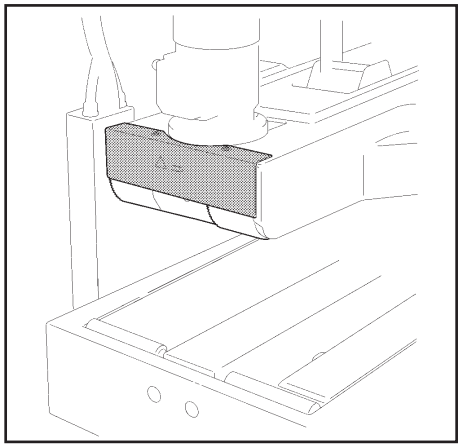
10.2 STOP DE EMERGENCIA

El botón de emergencia de retención está situado en una posición que se puede alcanzar con facilidad a la altura de la mano que cierra las solapas de la caja.



10.3 PROTECCIÓN METÁLICA

Protección de las correas superiores de arrastre.



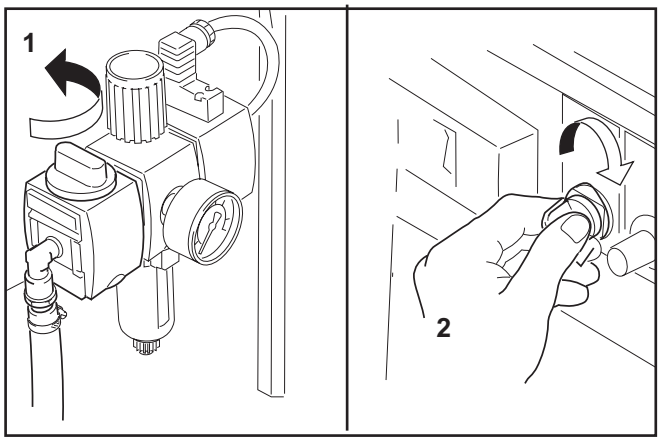
10.4 SISTEMA ELECTRICO

El sistema eléctrico está protegido por una toma de tierra, cuya continuidad es objeto de prueba y de control final, junto a la prueba de aislamiento y de rigidez dieléctrica del sistema (Véase la sección **ANEXOS 15.5**).

11-PREPARACION PARA EL USO Y REGULACION

11.1 SEGURIDAD

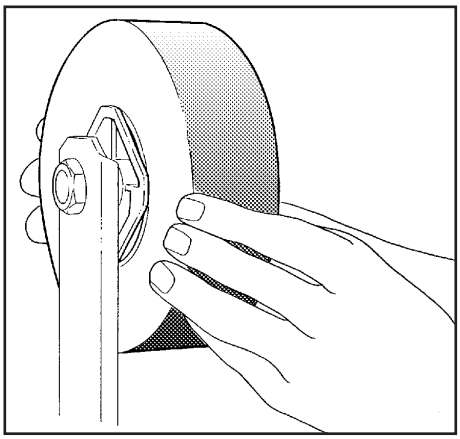
Todas las operaciones de preparación y de regulación tienen que ser efectuadas con la máquina parada y con el mando STOP EMERGENCIA retenido.



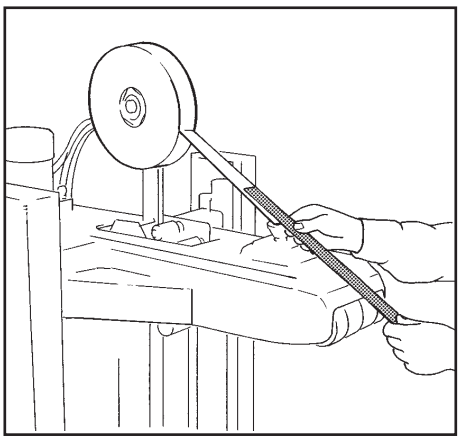
11.2 MONTAJE DE LA CINTA EN LA UNIDAD PRECINTADORA SUPERIOR

Activar el equipo pneumático girando en sentido antihorario el botón **1** y subir la cabecera superior girando en sentido horario el selector **2**.

Colocar una bobina de cinta en el brazo portarrollo, teniendo cuidado de ajustar la bobina hasta el fondo del brazo portarrollo.

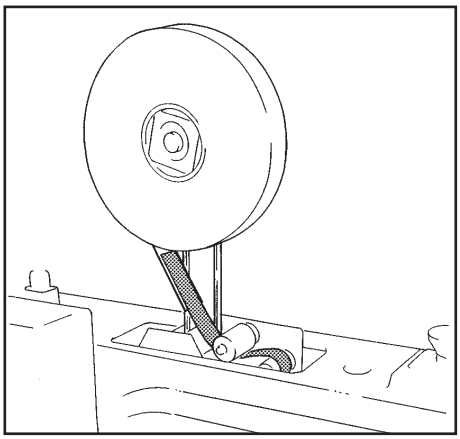


Pegar el borde al tensor de la cinta.



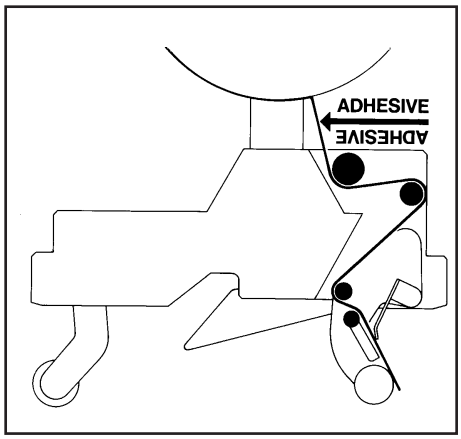
¡ATENCIÓN! Cuchilla muy afilada, puede provocar heridas serias.

Introducir la cinta en la unidad de precintado, manteniendo las manos, con extrema atención, fuera del alcance de las cuchillas corta-cinta. (**Véase el punto 3.11-g**).

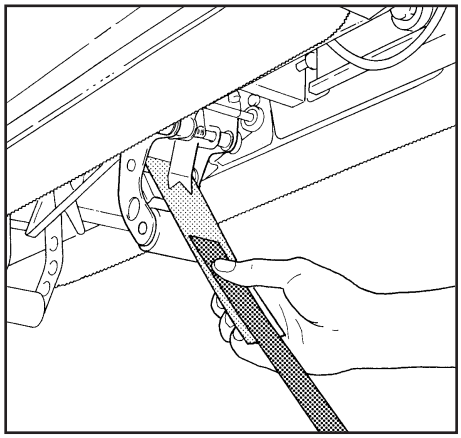


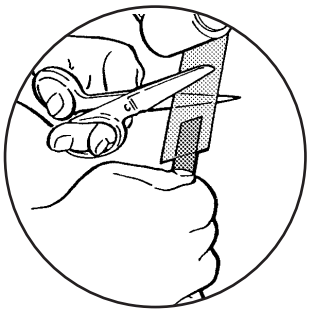
11-PREPARACION PARA EL USO Y REGULACION

Conseguir que la cinta recorra el tramo indicado en la Figura, prestando atención para que el lado adhesivo se encuentre en el lado indicado por la flecha.



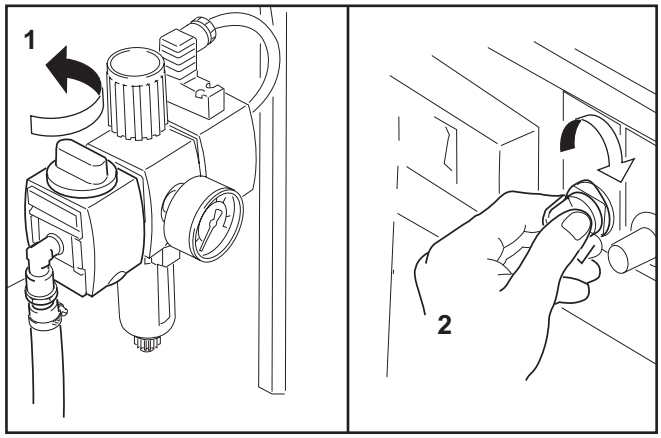
Tirar y cortar la cinta excedente usando las tijeras como en la Figura.



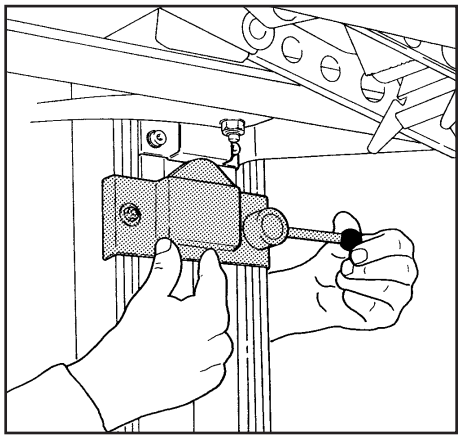


11.2 COLOCACION DE LA CINTA EN LA UNIDAD DE PRECINTADO INFERIOR

Activar el equiqo neumático, girando en sentido antihorario el botón **1** y levantar la cabecera superior girando en sentido horario el selector **2**.

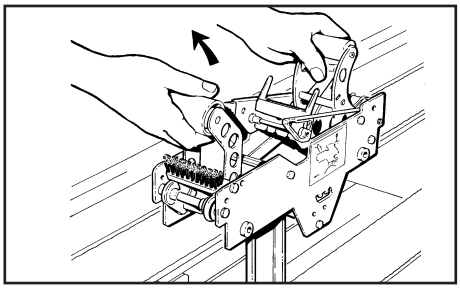


Levantar el retén contra la cabecera superior y bloquearlo con la palanca. Una vez sustituida la cinta, colocar el retén en su posición original.

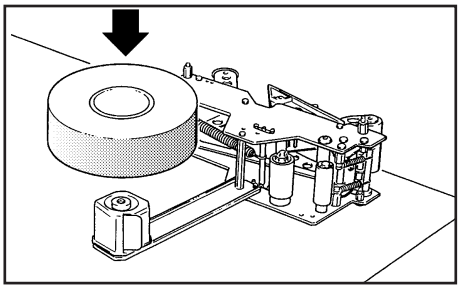


11-PREPARACION PARA EL USO Y REGULACION

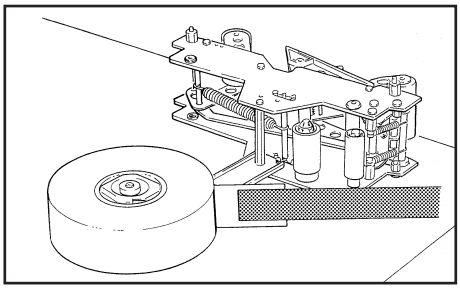
Extraer la unidad encintadora de su envoltura correspondiente y apoyarla en un plano de trabajo.



Colocar la bobina de cinta en el portabobinas.

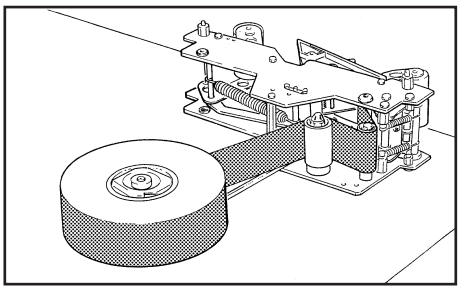


¡ATENCIÓN! Cuchilla muy afilada, puede provocar heridas serias.

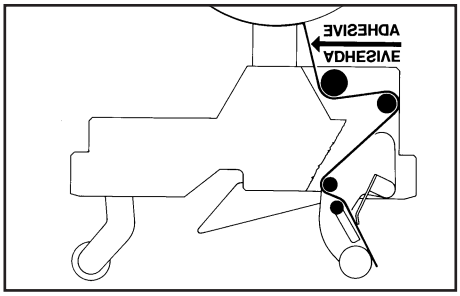


Pegar la cinta al tiracinta.

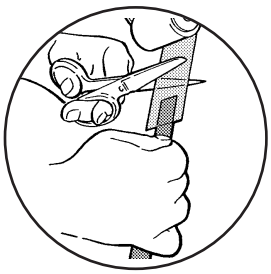
Introducir la cinta en la unidad de precintado, manteniendo las manos, con extrema atención, fuera del alcance de las cuchillas corta-cinta. (Véase el punto 3.11-g*)*.



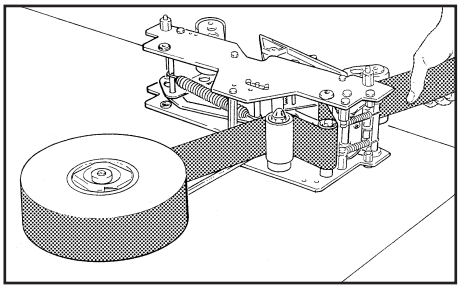
Conseguir que la cinta recorra el tramo indicado en la Figura, prestando atención para que el lado adhesivo se encuentre en el lado indicado por la flecha.



Tirar y cortar la cinta excedente.



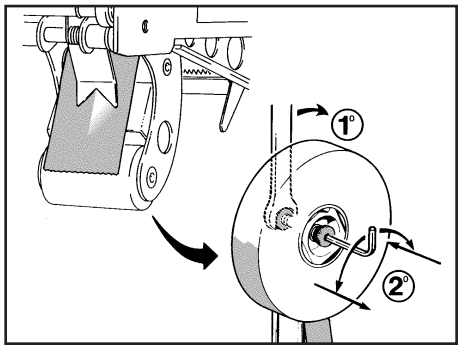
Volver a introducir la unidad precintadora en su alojamiento.



11-PREPARACION PARA EL USO Y REGULACION

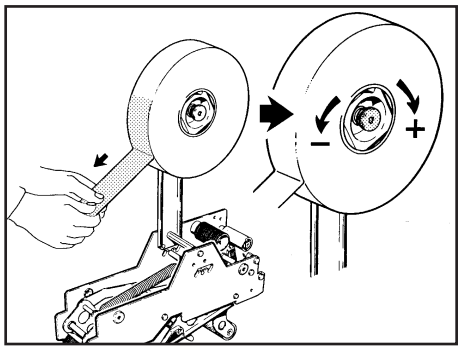
11.1 REGULACION DEL BRAZO PORTARROLLO

Verificar el centrado de la cinta en los rollos de la unidad.
Si fuera necesario, desbloquear la tuerca **1** y ajustar el tornillo **2**.



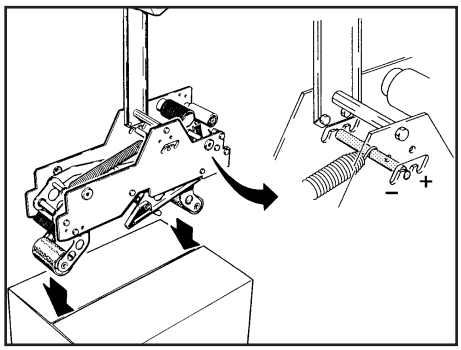
11.2 REGULACION DE LA FRICCION DE LA CINTA

Verificar la tensión de la cinta:
- Brazo del portarrollo libre para PVC
- Brazo del portarrollo ligeramente friccionado para OPP.



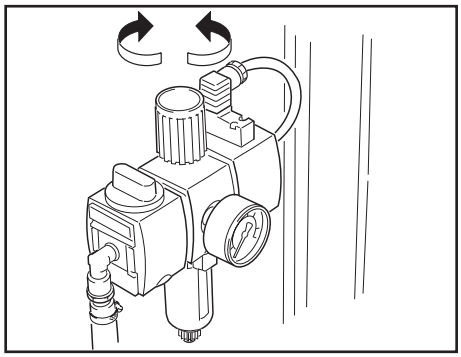
11.5 REGULACION DE LAS UNIDADES PRECINTADORAS PARA CADA TIPO DE CAJAS

Regular el muelle principal:
- para cajas ligeras dar una carga menor al muelle;
- para cajas robustas dar más carga al muelle.



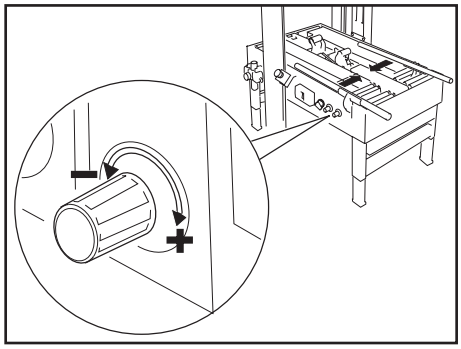
11.6 REGULADOR DE PRESIÓN

Regular la presión del aire según sea el espesor del cartón.
Presión máx. 6 Bar.



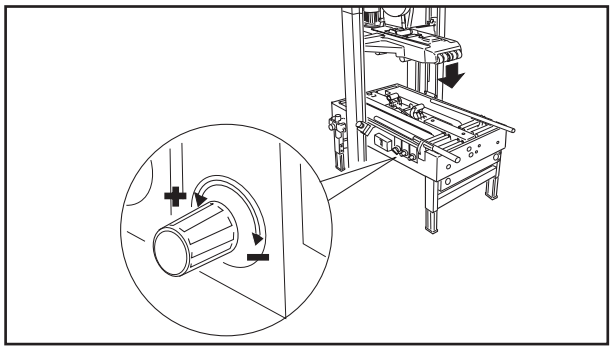
11.7 REGULACION DE LA PRESIÓN DE LAS GUIAS

Regular la presión de las guías laterales sobre las cajas.
Disminuir con cartones ligeros; aumentar con cartones más fuertes.



11.8 REGULACION PRESIÓN CABECERA SUPERIOR

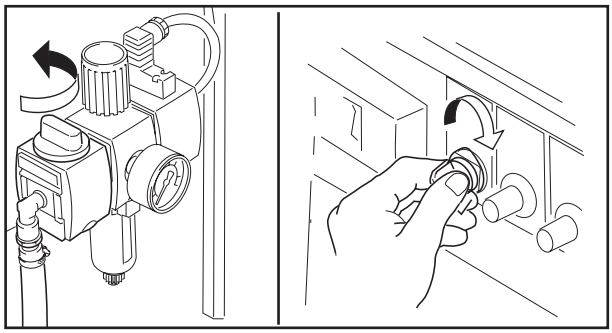
Regular la presión de la cabecera superior en la caja. Disminuir para cartones parcialmente vacios; aumentar cuando se requiere una mayor presión sobre el cartón.



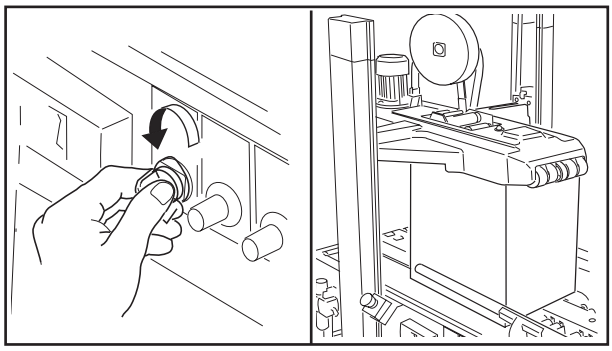
11.9 REGULACIÓN DE LA BAJADA DE LA CABECERA SUPERIOR (VELOCIDAD DE PRODUCCIÓN)

En condiciones normales la cabecera superior baja hasta una altura mínima de 110 mm., después de cada ciclo de precintado. El descenso de la cabecera superior puede limitarse cuando:
a) se cierran cajas con medidas diferentes y se sabe cual es la altura mínima entre las variadas medidas.
b) se cierran lotes de cajas de medida uniforme y se desea acelerar la producción de cada lote.

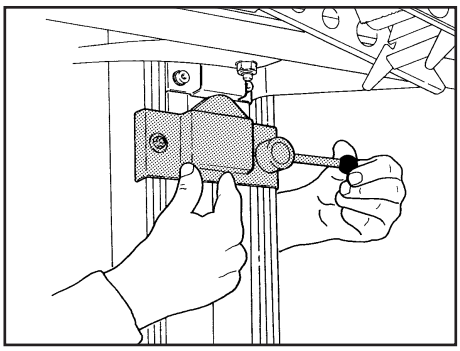
Para regular la altura mínima de la cabecera superior se procederá como sigue:



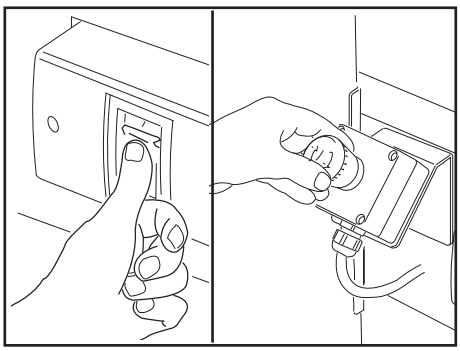
Girar el selector en sentido horario para alzar la cabecera.
Introducir la caja que se desea precintar y girar el selector en sentido anti-horario, haciendo bajar la cabecera hasta que apoye en la caja..



Situar el bloqueo contra la cabecera superior y bloquearlo utilizando la manilla correspondiente.



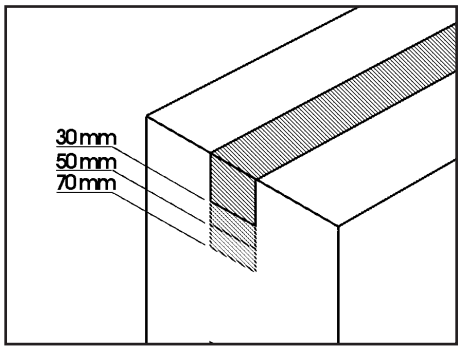
Girar el pulsador STOP EMERGENCIA en sentido horario y apretar el botón ON.
La caja será arrastrada por las correas superiores e inferiores, precintada y después expulsada por la máquina.



REGULACIONESPECIALES

11.10 MODIFICACIÓN DE LA LONGITUD DEL MARGEN DE LA CINTA

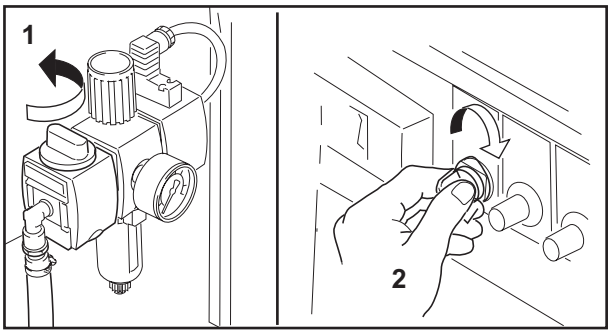
La longitud del margen de la cinta puede variar de 70 a 50 a 30 mm.
Para llevar a cabo esta regulación nos remitimos al manual de la unidad precintadora K12, suministrado con la máquina.



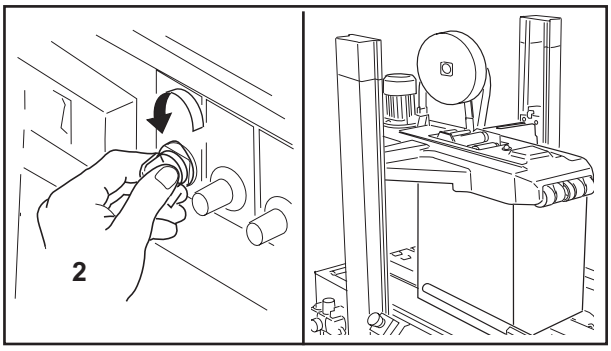
COLUMNAS FIJAS EN POSICIÓN ALTA

Para poder precintar cajas con una altura superior a 750 mm. y hasta 930 mm es necesario levantar las columnas de la máquina. Para ello se procederá como sigue:

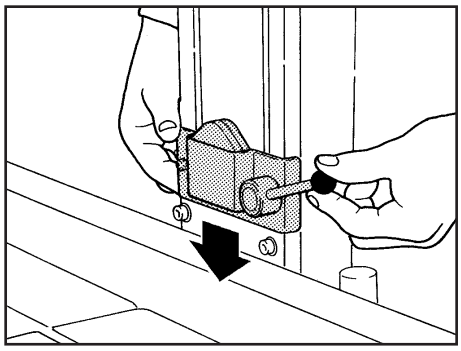
Activar el equigo pneumático girando en sentido anti-horario el mando **1** y alzar la cabecera superior girando en sentido horario el selector **2**.



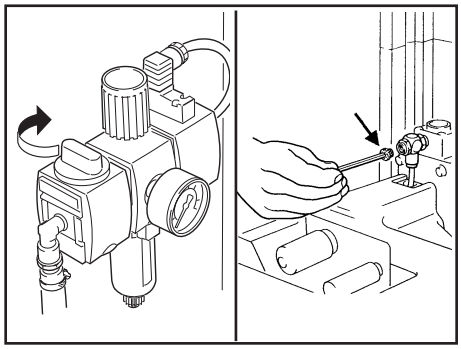
Introducir debajo de la cabecera una caja (altura 450 mm. aprox) suficientemente rígida como para soportar el peso de la cabecera (Kg. 45). Girar el selector **2** en sentido anti-horario haciendo bajar la cabecera hasta apoyarla en el soporte.



Desbloquear y bajar completamente el retén.

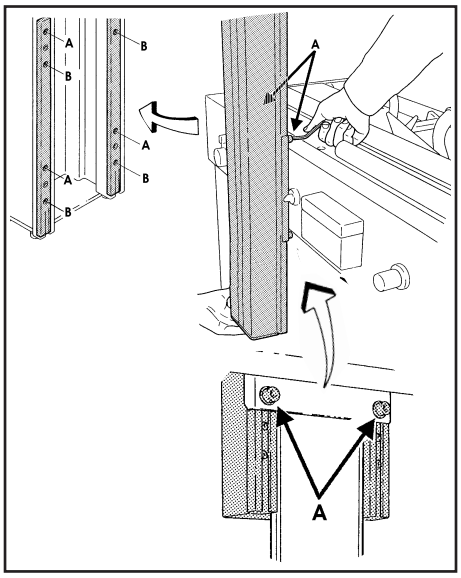


Desactivar el equipo pneumático girando el mando en sentido horario.
Quitar el tapón para que salga todo el aire del equipo pneumático.
Colocar y apretar el tapón..



Sujetar con una mano la columna y con la otra mano quitar los 4 tornillos **A**; empujar hacia arriba la columna hasta llegar a los orificios **B**. Volver a colocar los tornillos.

Volver a activar el equipo pneumático.

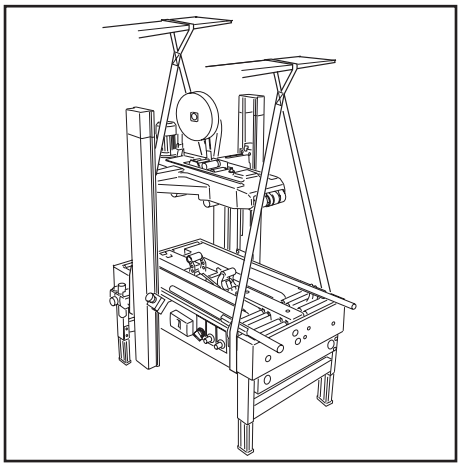


ACCESSORIOS OPCIONALES

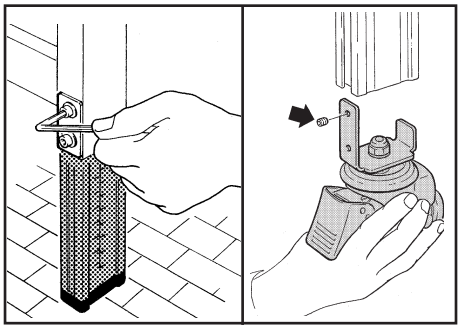
11.12 SET RUEDAS OPCIONALES (AS77)
(Código set: 7.8.04337.00B)

Para facilitar el traslado de la máquina es posible montar en la misma cuatro ruedas; por lo tanto varían la altura de la superficie de los rodillos y las dimensiones generales (parrafa

Levantar la máquina como demuestra la Tabla.



Quitar la tapeta e introducir la rueda y fijar con los dos tornillos, regular la altura de la superficie de rodillos, tomando como referencia la escala graduada.
(Altura de la rueda=100 mm.).

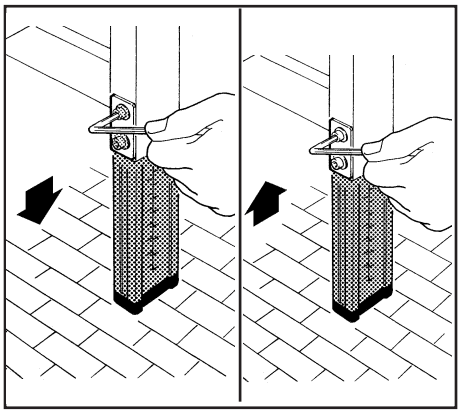


11.13 SET PIES OPCIONALES H= 600 (AS80)
(Código set: 7.8.04413.00A)

Para poder alzar la superficie de los rodillos, según indicado en la pág. 25, es necesario sustituir los pies.

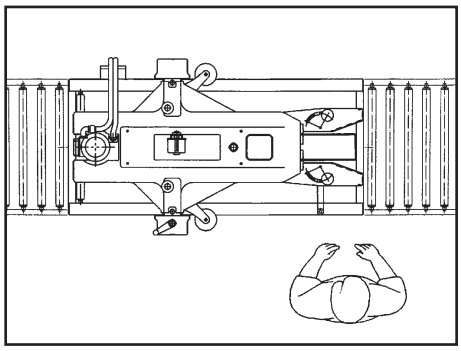
Levantar la máquina como se indica en la Tabla.
Desbloquear los tornillos y extraer los pies.

Montar los pies nuevos y bloquearlos tomando como referencia la escala graduada.



12-USO DE LA MAQUINA

12.1 POSICION CORRECTA DEL OPERADOR



12.2 PUESTA EN MARCHA

Pulsar ON en el interruptor principal.

12.3 INICIO DE LA PRODUCCION

Antes de empezar la producción, poner la máquina en funcionamiento en vacío y probar las seguridades (véase párrafo 12.8). Después proceder con el ciclo de trabajo.

12.4 SUSTITUCION DE LA CINTA

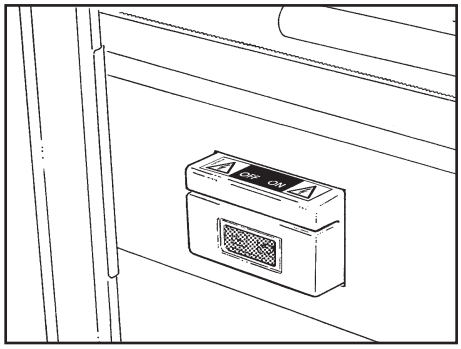
Prestar una atención especial a las cuchillas

.

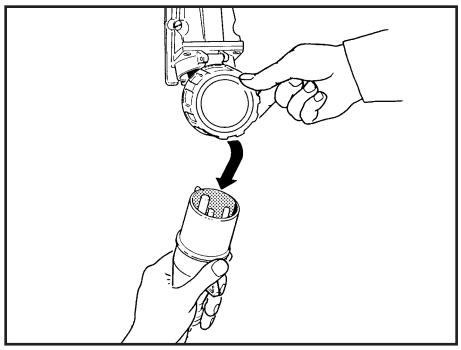
Especilización del operador número 1.
Cada vez que sea necesario sustituir la bobina de la cinta, actuar de la siguiente manera:
-pulsar el mando STOP EMERGENCIA de retención;
-repetir todas las operaciones mostradas en los puntos 11.1 y 11.2.

12.5 LIMPIEZA

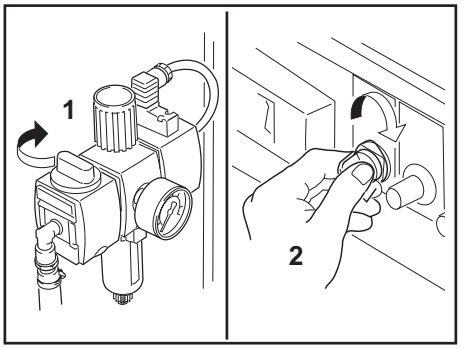
Antes de cada operación de limpieza o manutención para la máquina pulsando el mando STOP (OFF) en el interruptor principal.



Desconectar el enchufe del cuadro de alimentación.



Activar el equipo pneumático girando en sentido anti-horario el mando **1** y levantar la cabecera superior girando en sentido horario el selector **2.**
Bloquear la cabecera con el perno (véase parrafo 11.2).



LIMPIEZA - Especialización del operador **1**.
Utilizar ropas secas o soluciones detergentes suaves.

Está prohibido utilizar disolventes y chorros de agua.

12.6 TABLA RESUMEN DE LAS REGULACIONES

OPERACIONES	ESPECIALIZACION	CAPITULO
Cambio de cinta	1	11.1 - 11.2
Regulación de centrado de la cinta	1	11.3
Control de las seguridades	1	12.7
Regulación de la fricción de la cinta	1	11.4
Regulación de la bajada de la cabecera superior	1	11.9
Regulación de la presión de aplicación de la cinta	1	11.5
Regulación de altura del suelo	1	7.4
Presión aire	1	11.6
Regulaciones especiales: margen cinta	2	11.10
Regulaciones especiales: columnas fijas en posición alta	2	11.11

12.7 CONTROL DE EFICACIA DE LAS SEGURIDADES

1 Protección de la cuchilla de la unidad de la cinta (Parrafo 10.1)
2 Botón de emergencia con retención (parrafo 10.2)
3 Botón STOP (OFF) en el interruptor principal (parrafo 7.11.3; parrafo 9.1)

SITUACION	*CAUSA*	*REMEDIO*
Pulsando la tecla ON, el botón no permanece pulsado y la máquina no se enciende.	*Botón STOP EMERGENCIA pulsado.* *Cortocircuito en la instalación.*	*Desconectarlo girando el pomo en sentido contrario.* *Controlar.*
La protección magnetotérmica hace que el interruptor general bajo de la térmica en bloqueadas.	*Forzamiento del motor.* *Calibrado demasiado bajo de la térmica en el interruptor principal.*	*Controlar que las correas de tracción no estén bloqueadas.* *Controlar que la absorción de corriente indicada en la etiqueta de los motores no sea superior al valor de la térmica.*
El motor gira, pero las correas de tracción se paran.	*Correas aflojadas* *Poleas motrices deterioradas*	*Regular la tensión* *Comprobar el estado de desgaste de los anillos y sustituirlos en caso de necesidad.*
Las bandas de tracción giran pero no arrastran la caja.	*Correas de arrastre deterioradas.*	*Sustituirlas.*
La cabecera superior no baja o baja demasiado lenta/rápidamente.	*Selector subida/baja no accionado.* *Ha sido cambiado el ajuste de fábrica.*	*Girar en sentido anti-horario).* *Registrar la presión.*

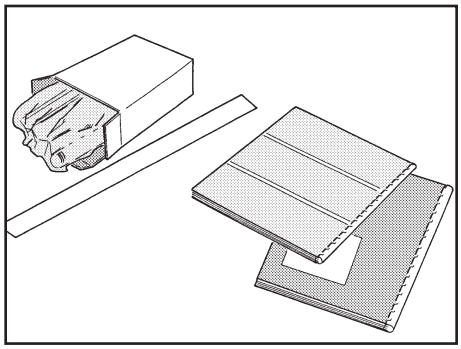
13-MANUTENCION Y REPARACION

13.0 SEGURIDAD

(Véase el punto 3)

El desarrollo de operaciones de manutención y reparación comporta situaciones peligrosas. Al proyectar esta máquina se han tenido en cuenta específicamente las normas EN292 Nov. 92/6.1.2 y EN292/2, Nov. 92/5.3.

13.1 INSTRUMENTOS Y RECAMBIOS EN DOTACION DE LA MAQUINA



1 N.1 cuchilla (cuchilla de recambio para unidad encintadora cód. S4004152ZZZ);
N. 1 Muelle principal BOTTOM (cód. S370017992Z);
N. 1 Muelle principal TOP (cód. S370017894Z);
N. 2 Muelles portacuchilla (cód. S37022794Z);
2 Tensor de la cinta (para introducir la cinta en las unidades, cód. S3.10091406Z);
3 Manual de la máquina (cód. SMB00049K)
4 Manual de la unidad precintadora (cód. S30.0024296A).

13.2 NATURALEZA Y FRECUENCIA DI CONTROLES E INTERVENCIONES DE MANUTENCION

OPERACIONES	FRECUENCIA	ESPECIALIDAD OPERADOR	CAPITULO
Lubrificación	Trimestral	**2**	**13.5-6-7**
Limpieza cuchilla	Semanal	**2**	**13.8**
Limpieza máquina	Semanal	**1**	**12.5**
Control dispositivo seguridad	Diaria	**1**	**13.4**
Sustitución cuchilla	//	**2**	**13.9**
Sustitución correas	//	**2**	**13.10**

13.3 CONTROLES QUE SE DEBEN EFECTUAR ANTES Y DESPUES DE CADA OPERACION DE MANUTENCION

Antes de cada operación de manutención, pulsar la tecla OFF en el interruptor principal y quitar el enchufe del cuadro general.

Durante la fase de manutención debe estar presente junto a la máquina sólo la persona encargada de la misma y nadie más.

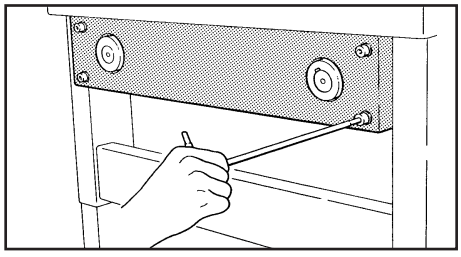
Al final de cada operación de manutención controlar el estado de funcionamiento de todos los dispositivos de seguridad y de las protecciones contra infortunios.

CONTROL DE EFICIENCIA DE LAS SEGURIDADES

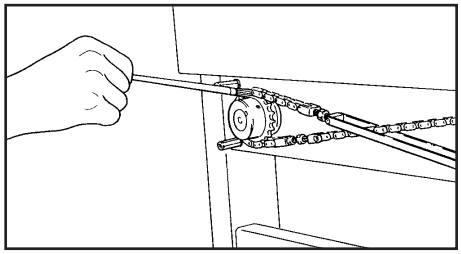
1 Protección de la cuchilla de la unidad precintadora (Párrafo 10.1)
2 Botón de emergencia de retención(Párrafo 10.1)
3 Botón STOP (OFF) con interruptor principal (Párrafo 7.11.3; 9.1)

13.5 LUBRIFICACIÓN DE LA MÁQUINA

Quitar la tapa.

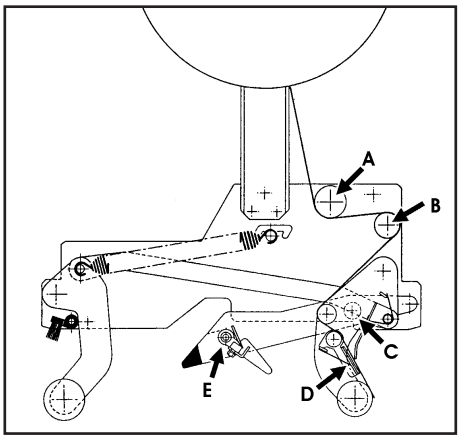


Lubrificar trimestralmente con grasa metal/metal la cadena y los piñones.



13.6 PRODUCTOS PARA LA LUBRIFICACION

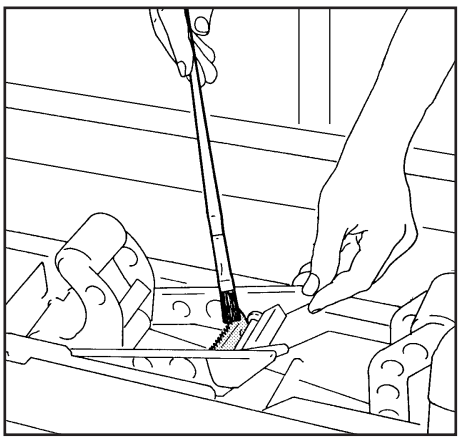
Grasa tipo:
METAL/METAL: B. C. 190 HEAVY DUTY
(o grasa para cadenas o rodamientos)
METAL/PLASTICO: PLATE MASTER M+L (grasa de molibdeno y PTFE para materiales plásticos y metal)
Aceite:
Aceite lubrificante normal o lubricante hidro-repelente spray multiuso.



13.7 LUBRIFICACION DE LA UNIDAD PRECINTADORA

Lubrificar mensualmente los puntos indicados en la Tavola con aceite lubrificante normal.

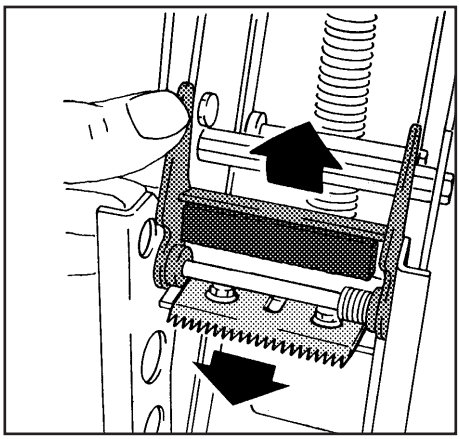
A Perno de enganche del muelle
B Perno de tensión del muelle
C Perno del rodillo sin retorno
D Cremallera portacuchilla
E Perno de protección de la cuchilla



13.8 LIMPIEZA DE LA CUCHILLA

Especialidad del operador 2
Alzar la protección y limpiar la cuchilla con un pincel (de mango largo) y aceite. El aceite evita la acumulación de material adhesivo.

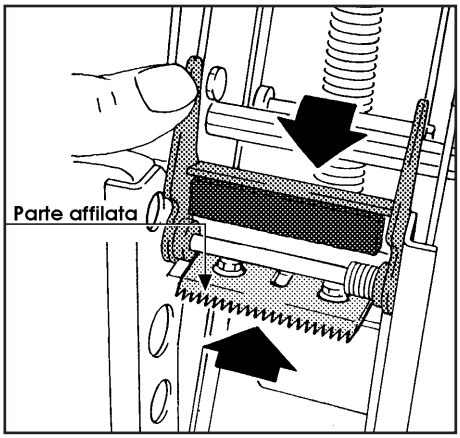
13.9 SUSTITUCIÓN DE LA CUCHILLA



Especialidad del operador 2.
- Elevar la protección de la cuchilla como se ilustra en la Figura.
- Aflojar los tornillos.
- Extraer la cuchilla.

¡ATENCION!
La cuchilla está muy afilada.
Un error durante esta operación puede provocar heridas de gravedad.

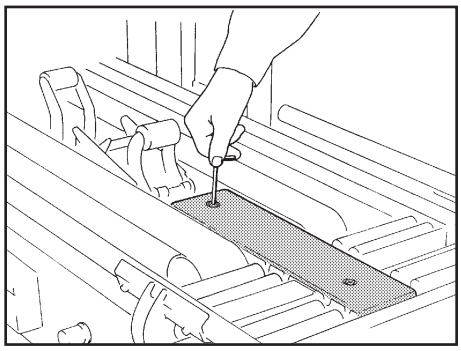
- Introducir la nueva cuchilla prestando atención a la posición exacta de la parte afilada.
- Apretar los tornillos.
- Soltar la protección.



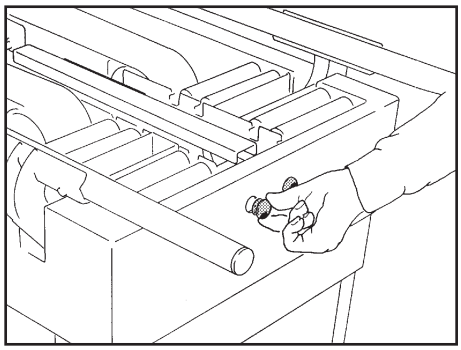
13.10 SUSTITUCIÓN DE LAS CORREAS DE TRACCIÓN INFERIOR

Especialidad del operador 2

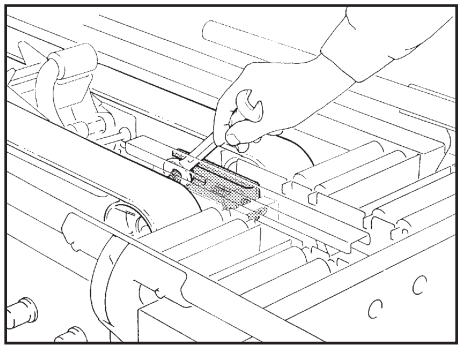
- Quitar los dos tornillos.
- Extraer el cárter.



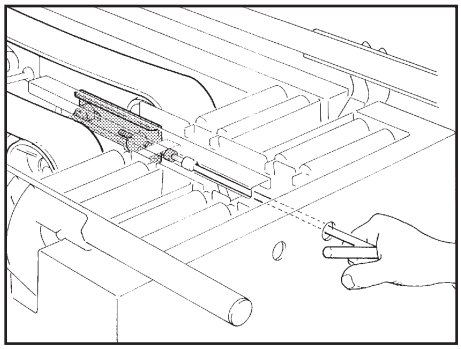
- Quitar los dos tapones.



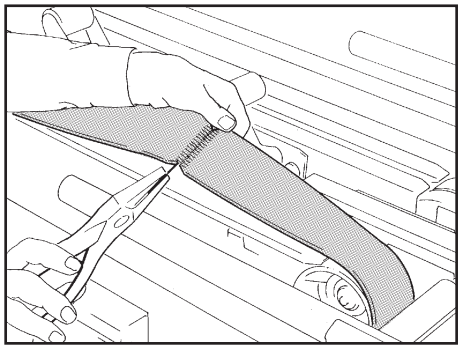
- Aflojar la tuerca de bloqueo.



- Aflojar el tornillo de tensado.



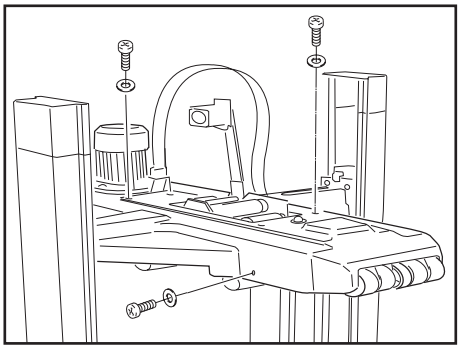
- Cortar la correa desgastada.
- Colocar una nueva correa.
- Introducir entre las mallas de unión un perno de nylon.
- Regular la tensión de la correa.



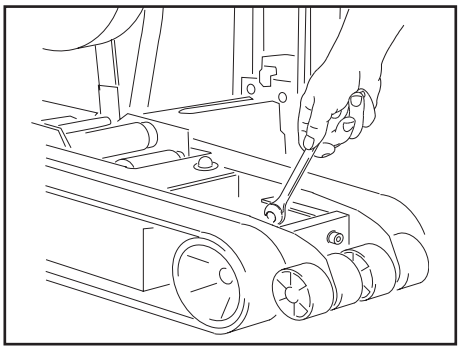
13.11 SUSTITUCIÓN DE LAS CORREAS DE TRACCIÓN SUPERIORES

Especialidad del operador **2**.

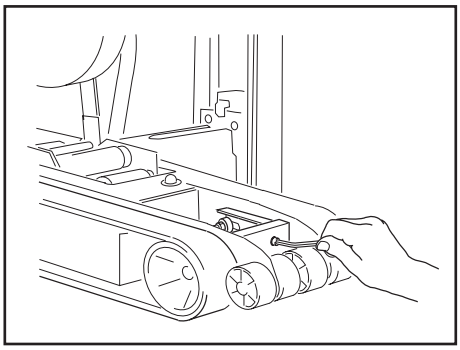
-Quitar los diez tornillos que fijan el cárter y extraerlo.



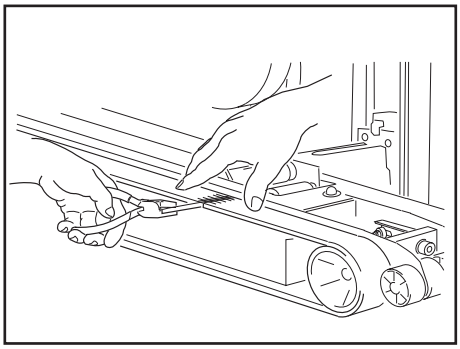
- Aflojar el tornillo de bloqueo.



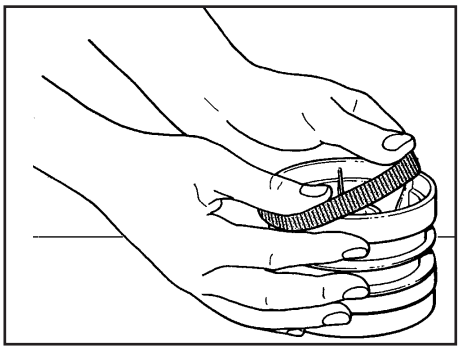
- Aflojar el tornillo de tensión.



- Cortar la correa desgastada.
- Colocar una nueva correa.
- Introducir entre las mallas de unión un perno de nylon.
- Regular la tensión de la correa.

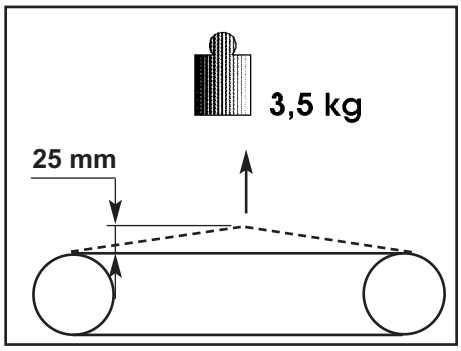


¡ATENCION!
Antes de insertar la nueva correa, comprobar la condición de los anillos de plástico naranja en las poleas motrices: sostituirlos en caso de necesidad.



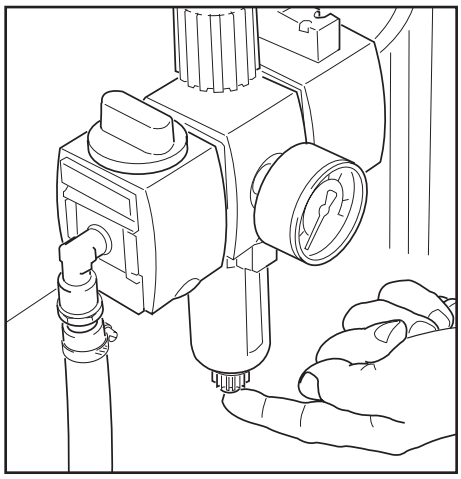
13.2 REGULACION DE LA TENSION DE LAS CORREAS

Controlar la tensión de la banda elevándola desde el centro; se debe separar alrededor de 25 mm. con una tracción de 3.5 kg.



¡IMPORTANTE!

Cada vez que se acumule condensado en el filtro, éste deberá ser extraído haciendo una ligera presión en la parte inferior del vaso, como se muestra en la Tabla.



REGISTRO DE LAS REPARACIONES EFECTUADAS EN LA MAQUINA

Fecha	DESCRIPCIÓN DE LA OPERACIÓN

i14-INSTRUCCIONES SUPLEMENTARIAS

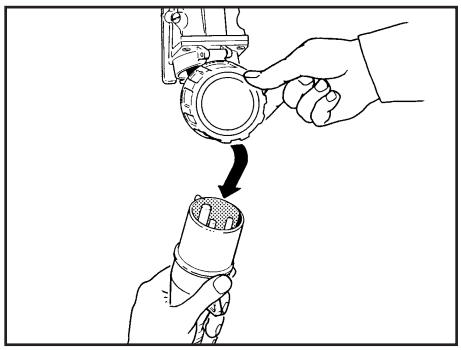
14.1 INDICACIONES PARA LA ELIMINACION DE LA CHATARRA

Materiales que componen la maquina:

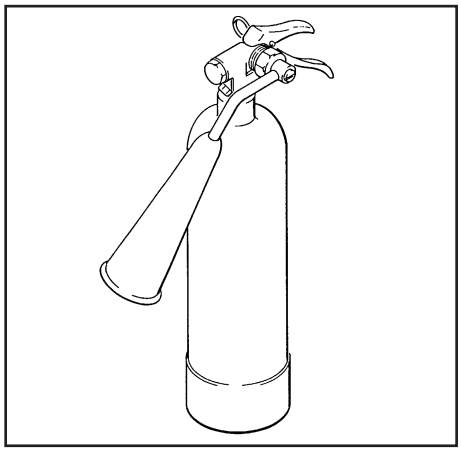
- Estructura de acero;
- Rodillos de deslizamiento de nylon;
- Correas de arrastre de PVC;
- Poleas de nylon.

En caso de eliminación de los materiales que componen la máquina, actuar según las normas vigentes en su país.

14.2 INSTRUCCIONES EN SITUACIONES DE EMERGENCIA



En caso de peligro/incendio:
Desconectar el cuadro general.



INCENDIO
En caso de incendio, utilizar extintores que contengan CO2
No utilizar agua.

15-ANEXOS

15.1 DECLARACION DE CONFORMIDAD

con la directiva 98/37 CEE; 91/386; 93/44 y 93/68 .

15.2 SEÑALES DE SEGURIDAD

Las etiquetas pegadas en la máquina son importantes para la seguridad del operador.
En el caso de deterioro o pérdida de cualquiera de las etiquetas, es responsabilidad del operador sustituirla inmediatamente.
Para pedir las etiquetas de recambio, se ruega hacer referencia a los números de código indicados en la Figura 5709 del catálogo recambios.

15.3 INDICACIONES SOBRE LAS EMISIONES DE RADIACIONES, GAS, VAPORES, POLVO

Ninguna indicación.

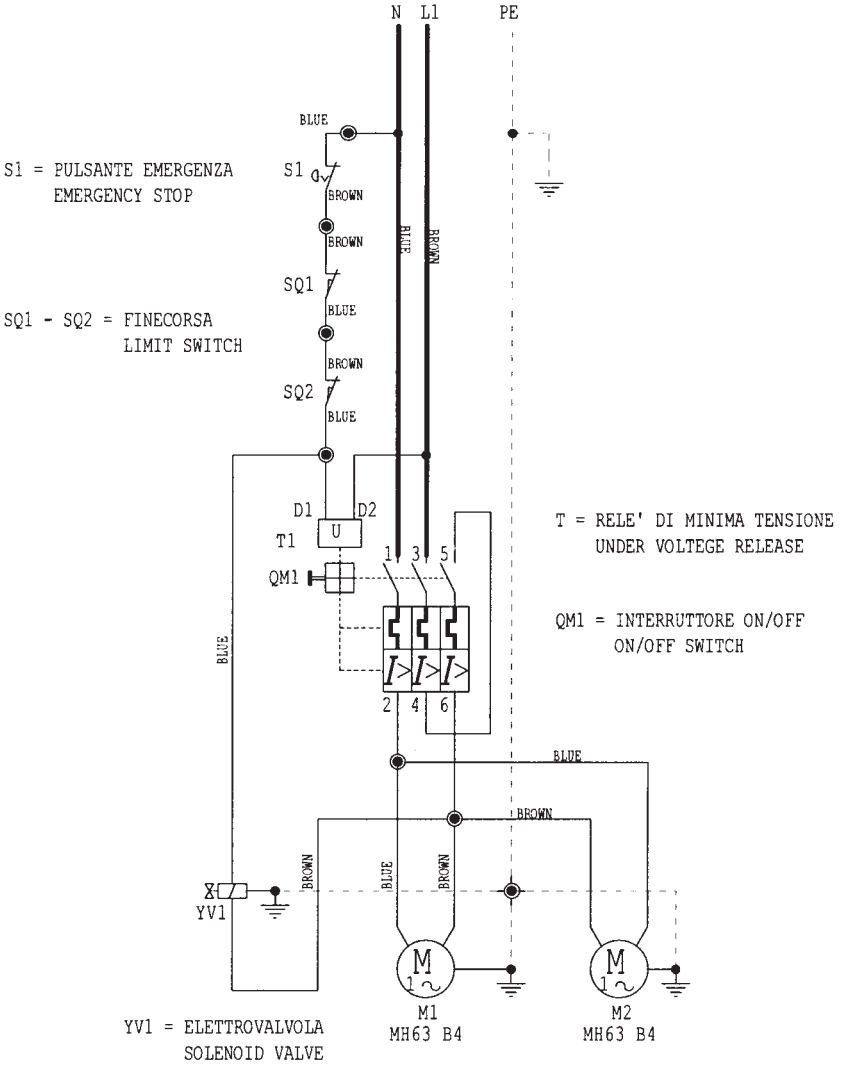
15.4 COMPONENTES DE SEGURIDAD

- interruptor STOP EMERGENCIA con retención

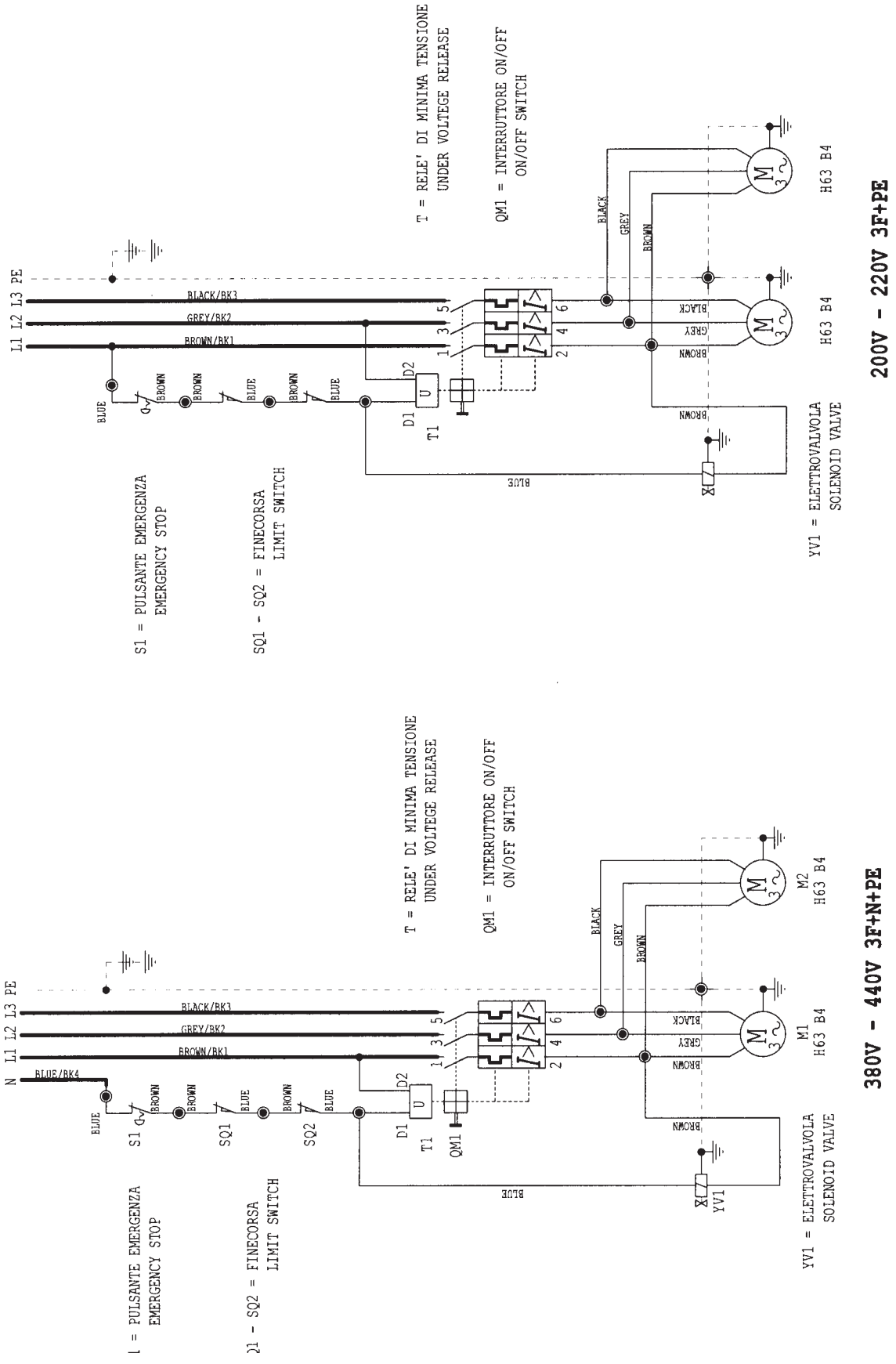
Nota : los componentes de seguridad tienen que ser indicados a todos los operadores de la máquina/oficina de recambios, para que no falten y se pidan con absoluta prioridad.
UTILIZAR SOLO RECAMBIOS ORIGINALES.

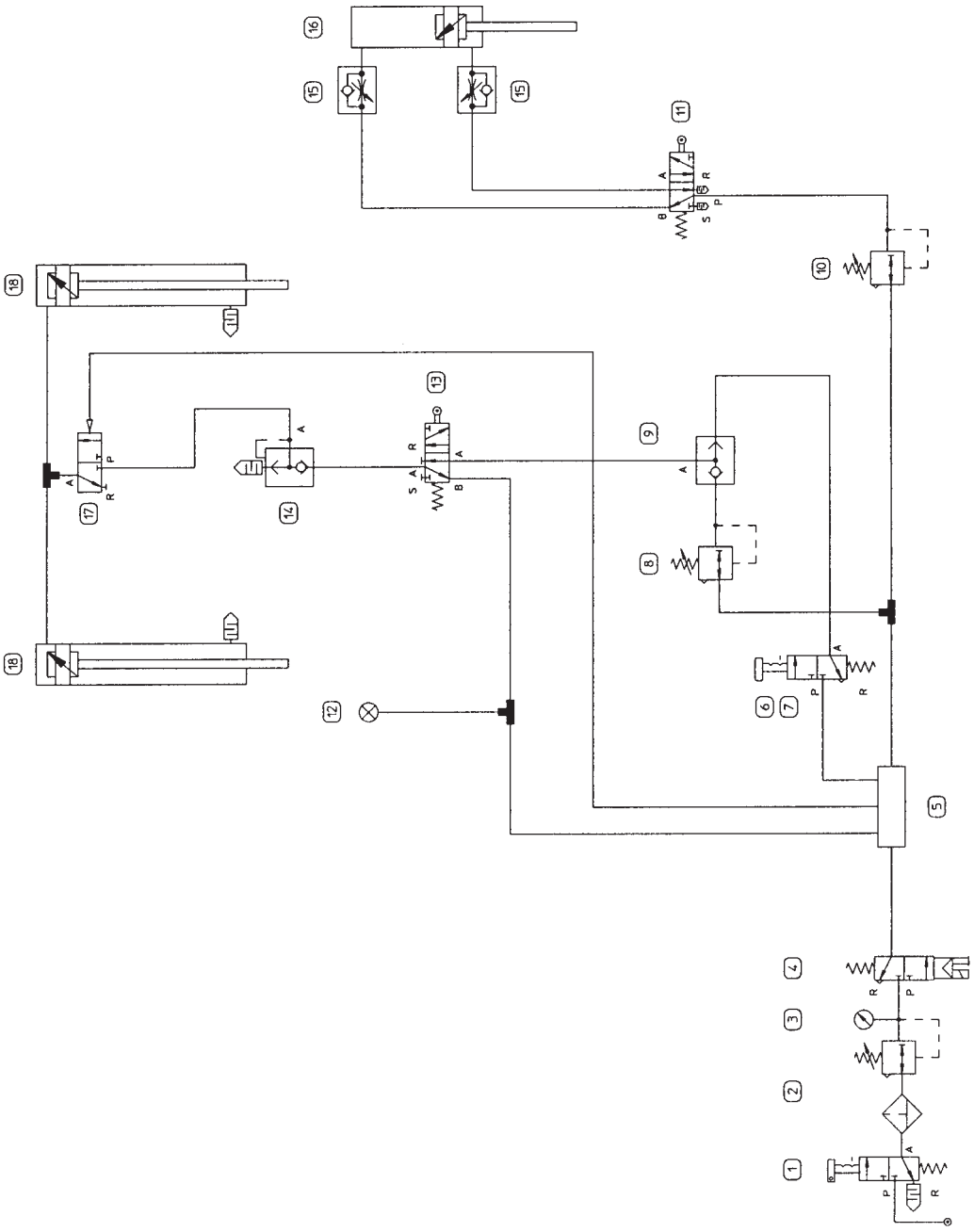
15.5 PRUEBAS ELECTRICAS

Pruebas eléctricas:
1 - Continuidad del cirucito de protección
2 - Resistencia de aislamiento
3 - Tensión de aislamiento
Con referencia EN 60204-1, Par. 20.2, 20.3, 20.4



100V - 240V MF+PE


200V - 220V 3F+PE
L1 L2 L3 PE
BLACK/BK3
GREY/BK2
BROWN/BK1
BLUE
BROWN
BLUE
BROWN
BLUE
BROWN
BLUE
D2
D1
T1
T = RELE' DI MINIMA TENSIONE
UNDER VOLTEGE RELEASE
QM1 = INTERRUTTORE ON/OFF
ON/OFF SWITCH
BLACK
GREY
BROWN
M
3~
H63 B4
BLACK
GREY
BROWN
M
3~
H63 B4
BROWN
BLUE
YV1 = ELETTROVALVOLA
SOLENOID VALVE
S1 = PULSANTE EMERGENZA
EMERGENCY STOP
SQ1 - SQ2 = FINECORSA
LIMIT SWITCH
380V - 440V 3F+N+PE
N L1 L2 L3 PE
BLACK/BK3
GREY/BK2
BROWN/BK1
BLUE/BK4
BLUE
BROWN
BLUE
BROWN
BLUE
BROWN
BLUE
S1
SQ1
SQ2
D2
D1
T1
QM1
T = RELE' DI MINIMA TENSIONE
UNDER VOLTEGE RELEASE
QM1 = INTERRUTTORE ON/OFF
ON/OFF SWITCH
BLACK
GREY
BROWN
M
3~
M2
H63 B4
BLACK
GREY
BROWN
M
3~
M1
H63 B4
BROWN
BLUE
YV1
YV1 = ELETTROVALVOLA
SOLENOID VALVE
1 = PULSANTE EMERGENZA
EMERGENCY STOP
Q1 - SQ2 = FINECORSA
LIMIT SWITCH


16
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3
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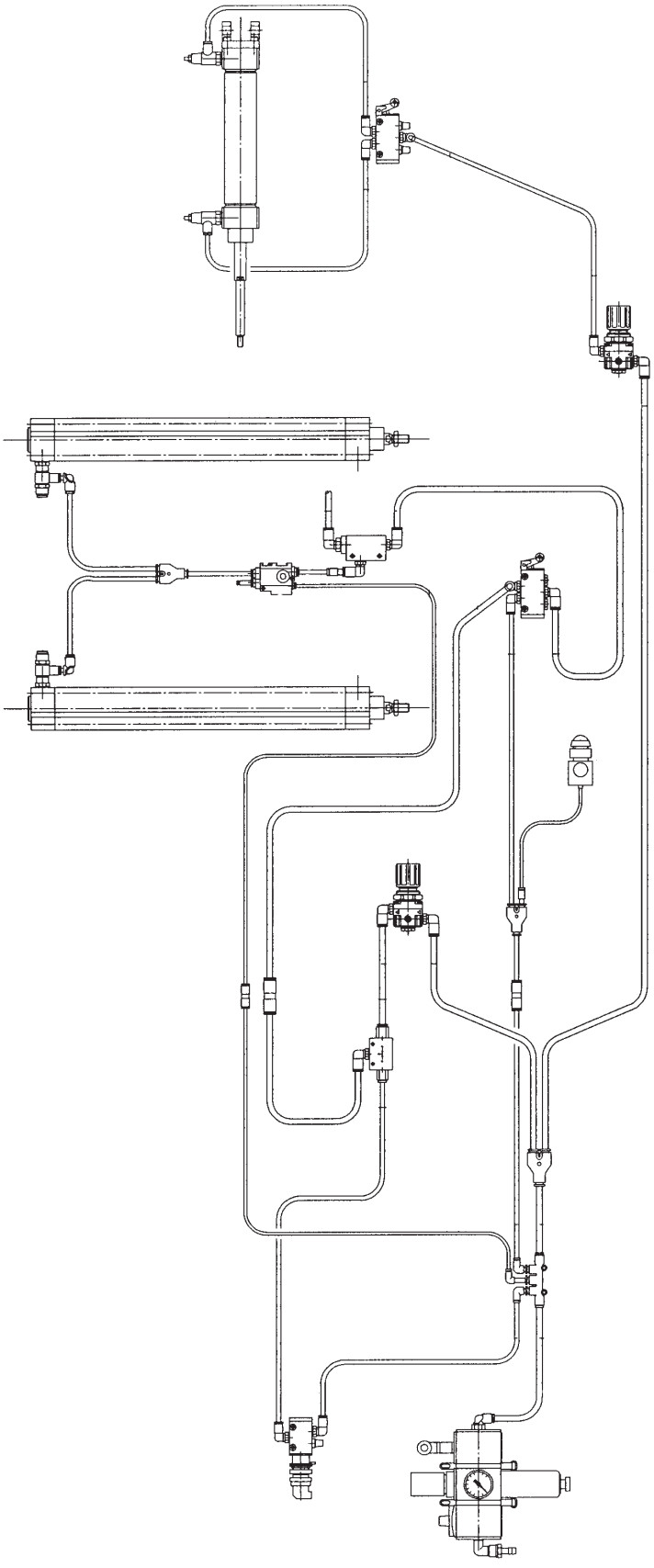
1
R
P
A
P
R



CATALOGO PEZZI DI RICAMBIO
COME ORDINARE

Per ordinare i pezzi di ricambio si prega di indicare nell'ordine:
MODELLO ESATTO DELLA MACCHINA/NUMERO DI MATRICOLA DELLA MACCHINA/NUMERO DELLA FIGURA DEL CATALOGO RICAMBI IN CUI COMPARE IL PEZZO RICHIESTO/NUMERO DI POSIZIONE DEL PEZZO RICHIESTO NELLA FIGURA/NUMERO DI CODICE DEL PEZZO/DESCRIZIONE DEL PEZZO/QUANTITÁ DESIDERATA

ATTENZIONE: LA MACCHINA VIENE COSTANTEMENTE MIGLIORATA DAI PROGETTISTI, E IL CATALOGO DEI RICAMBI SUBISCE PERIODICI AGGIORNAMENTI. É INDISPENSABILE CHE OGNI ORDINE DI PARTI DI RICAMBIO MENZIONI IL NUMERO DI MATRICOLA DELLA MACCHINA, LEGGIBILE SULLA TARGHETTA METALLICA DI IDENTIFICAZIONE DELLA MACCHINA.
Il costruttore si riserva la facoltà di apportare modifiche alle macchine senza preavviso.

SPARE PARTS CATALOGUE
HOW TO ORDER

When ordering spare parts, please define each part as follows:
MODEL OF MACHINE/SERIAL NUMBER OF MACHINE/NUMBER OF THE FIGURE IN THE SPARE PARTSCATALOGUE IN WHICH THE REQUESTED PARTS APPEARS/NUMBER OF POSITION OF THE REQUESTED PART IN THE FIGURE/PART NUMBER/DESCRIPTION/ DESIRED QUANTITY

WARNING: THE MACHINE IS CONSTANTLY REVISED AND IMPROVED BY OUR DESIGNERS. THE SPARE PARTS CATALOGUE IS ALSO PERIODICALLY UPDATED. IT IS VERY IMPORTANT THAT ALL THE ORDERS OF SPARE PARTS MAKE REFERENCE TO THE SERIAL NUMBER OF THE MACHINE, WHICH IS PUNCHED ON THE METAL NAME PLATE ON THE MACHINE.
The manufacturer reserves the right to modify the machine at any time without notice.

CATALOGUE PIECES DETACHEES
COMMENT COMMANDER

Pour commander les pièces de rechange, il est nécessaire d'indiquer dans l'ordre:
MODELE EXACTE DE LA MACHINE/NUMÉRO D'IDENTIFICATION DE LA MACHIN/NUMÉRO DU TABLEAU DANS LE CATALOGUE PIECES DE RECHANGE DANS LEQUEL FIGURE LA PIECE DEMANDÉE/NUMÉRO DE POSITION DANS LE CATALOGUE DE LA PIECE DEMANDÉE CODE DE LA PIECE/DESCRIPTION/QUANTITÉ DÉSIRÉE

ATTENTION;:La machine est améliorée constamment par des projetteurs, et le catalogue des pièces de rechange subit périodiquement des mises à jour. Il est donc indispensable, que chaque commande de pièces de rechange mentionne le numéro d'identification de la machine, lisible sur la plaque métallique d'identification de la machine.
Le constructeur se réserve le droit d'apporter des modifications aux machines sans préavis aucun.

ERSATZTEILE-KATALOG
ERSATZTEIL-BESTELLUNG

Für die Bestellung der Ersatzteile , müssen folgende Informationen mitgeteilt werden
GENAUES MASCHINENMODELL/
MATRIKELNUMMER DER MASCHINE/BILDNUMMER DES ERSATZTEILEKATALOGES, AUF DEM DAS GEFRAGTE TEIL BGEBILDET IST/ POSITIONSNUMMER DES GEFRAGTEN TEILES AUF DEM BILD/BESTELLNUMMER DES ERSATZTEILE/BESCHREIBUNG DES ERSATZTEILES/ GEWÜNSCHTE MENGE

ACHTUNG: DIE QUALITÄT UND SICHERHEIT DER MASCHINE WIRD VON DER ENTWICKLUNGSARBEIT STÄNDIG VERBESSERT. DER ERSATTEILE KATALOG WIRD PERIODISCH AKTUALISIERT. ES IST DAHER NOTWENDIG, DAß ALLE ERSATZTEIL-BESTELLUNGEN IMMER DIE MATRIKELNUMMER ERWÄHNEN, DIE AUF DEM METALLSCHILD DER MASCHINE STEHT.
Der Hersteller behält sich die Möglichkeit vor, eventuelle Änderungen an der Maschine ohne Vorabinformation durchzuführen.

CATALOGO PIEZAS DE RECAMBIO
COMO PEDIR

Para pedir las piezas de recambio se ruega indicar en el pedido:
MODELO EXACTO DE LA MÁQUINA/ NÚMERO DE MATRÍCULA DE LA MÁQUINA/NÚMERO DE LA FIGURA DEL CATÁLOGO RECAMBIOS EN LOS QUE APARECE LA PIEZA PEDIDA/ NÚMERO DE POSICIÓN DE LA PIEZA SOLICITADA EN LA FIGURA/ NÚMERO DE CÓDIGO DE LA PIEZA/ DESCRIPCIÓN DE LA PIEZA/CANTIDAD DESEADA

ATENCIÓN!: LA MÁQUINA ES CONSTANTEMENTE MEJORADA POR LOS PROYECTISTAS, POR LO QUE EL CATÁLOGO DE RECABIOS ES ACTUALIZADO PERIÓDICAMENTE. ES INDISPENSABLE QUE TODOS LOS PEDIDOS DE PIEZAS DE RECAMBIO HAGAN MENCI DEL NÚMERO DE MATRÍCULA DE LA MÁQUINA, LEGIBLE EN LA PLACA METÁLICA DE IDENTIFICACIÓN DE LA MÁQUINA.
El fabricante se reserva la facultad de aplicar modificaciones a las máquinas sin previo aviso.

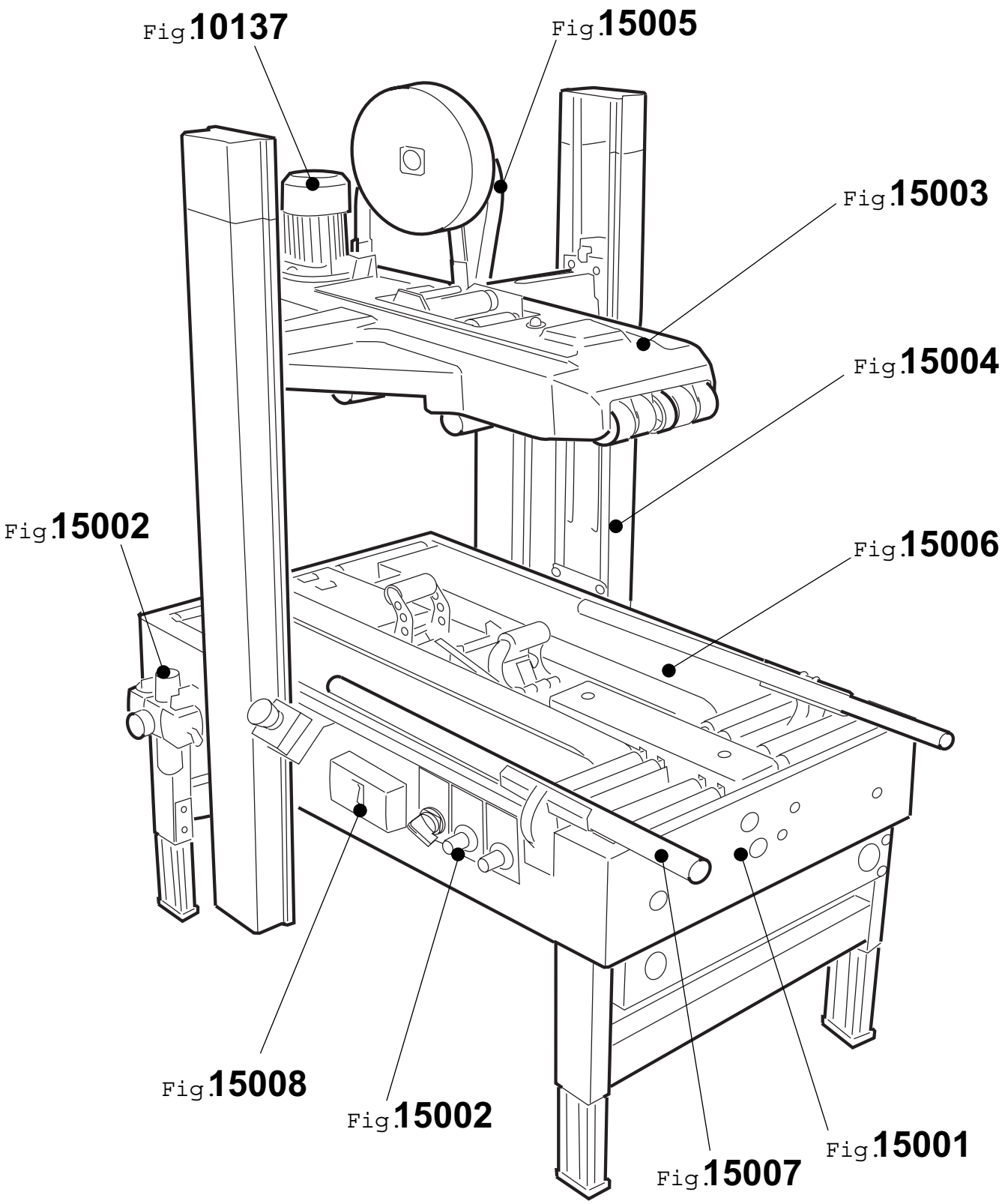


Fig.10137
Fig.15005
Fig.15003
Fig.15004
Fig.15002
Fig.15006
Fig.15008
Fig.15002
Fig.15007
Fig.15001

Fig. 10137 MOTORI ELETTRICI SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
1	2,0000	PZ	S3803442ZZZ	MOTORE H63 A4 B5 KW0.13 200V 50/60HZ 22
2	2,0000	PZ	S3803440ZZZ	MOTORE H63 A4 B5 220/240V-380/415V 50HZ
3	2,0000	PZ	S3803446ZZZ	MOTORE MULTITENSIONE MH63 C4 KW0,12 B5
4	2,0000	PZ	S3803449ZZZ	MOTORE MH63 C4 B5 220/240V MF 50HZ 0.13K
5	8,0000	PZ	S340005893Z	VITE TE M8X25 ZINCATA
6	8,0000	PZ	S340006392Z	RONDELLA ELAST.GROWER DIN 7980 (SEZ.QUADR
7	8,0000	PZ	S340011693Z	DADO BASSO M8 ZINC.
8	1,0000	PZ	S3802139ZZZ	BOCCHETTONE SKINTOP ST11
9	1,0000	PZ	S380809200A	CONNETTORE QUICKON-ONE DA 0.75 A 1.5 Q 1

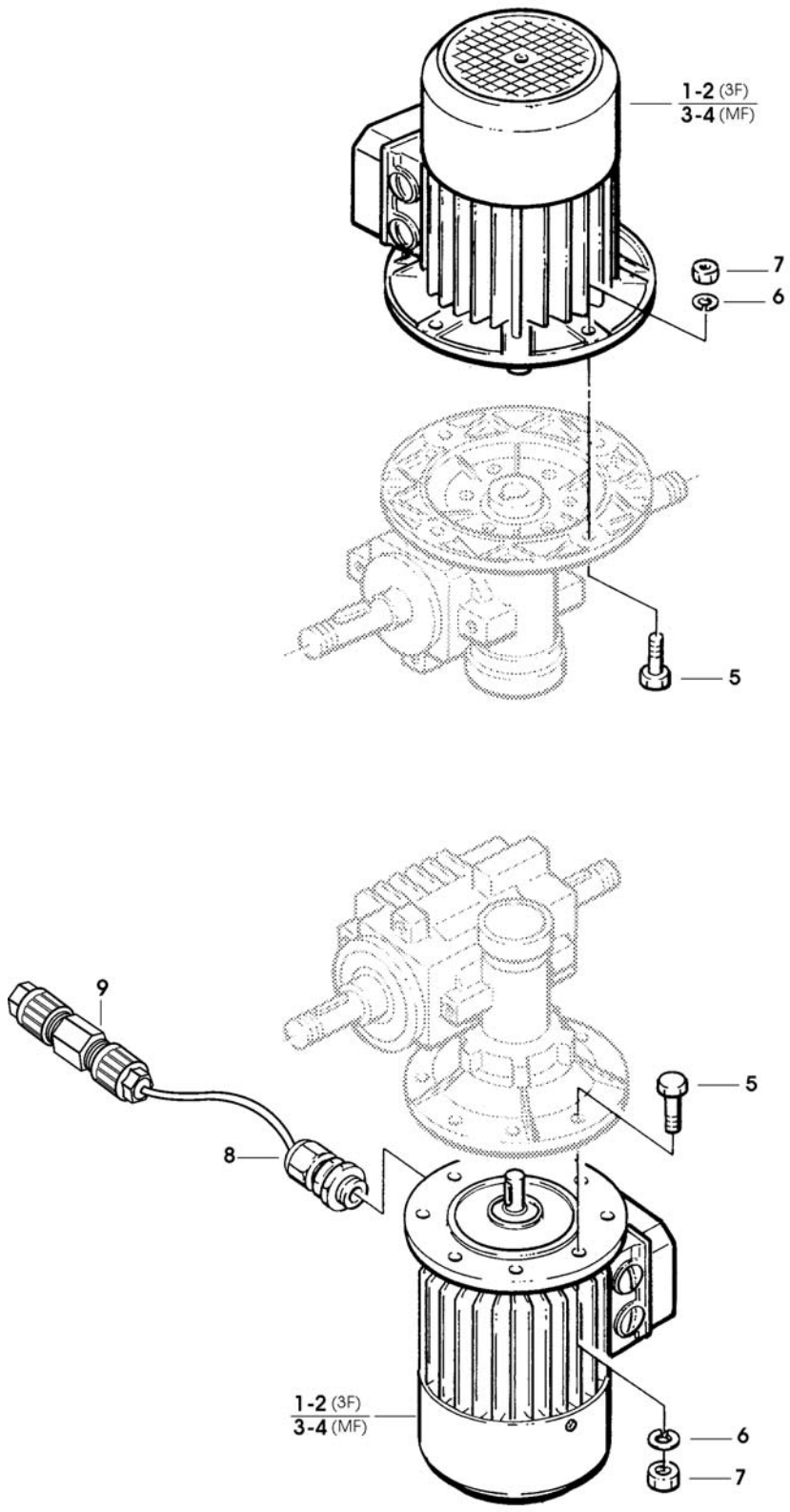
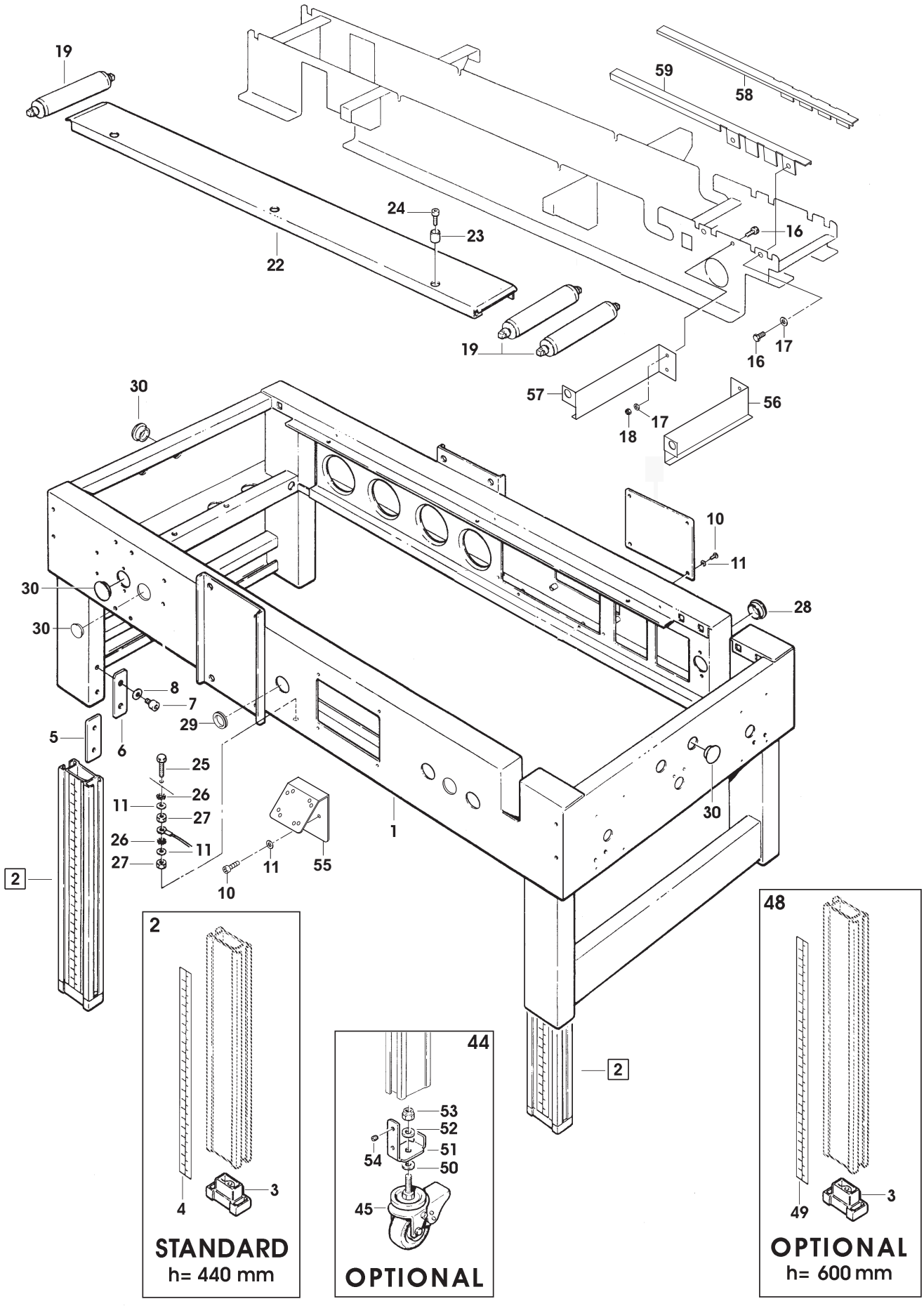

1-2 (3F)
3-4 (MF)
7
6
5
9
8
5
1-2 (3F)
3-4 (MF)
6
7

Fig. 15001 BANCALE SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
1	1.0000	pz	SBA0004743	Bancale assemblato c/inserti
2	4.0000	PZ	S4304737ZZZ	GAMBA CON PIEDINO SA2 SR4
3	4.0000	PZ	M3101498ZZZ	PIEDINO SERIE 2000 NERO
4	4.0000	PZ	S300098295A	RIGHELLA MILLIM PER GAMBA H=440 SA2-SR4
5	4.0000	PZ	S320567193A	PIASTRINA FISS.GAMBA
6	4.0000	PZ	S320589893A	STAFFA PER GAMBE E TRAVERSE SIAT 2000
7	8.0000	PZ	S340058493Z	VITE TCEI M8X16 ZINCATA
8	10.000	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
10	6.0000	PZ	S340031893Z	VITE TCEI M5X12 ZINCATA
11	8.0000	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
12	1.0000	PZ	S320588847A	PIASTRA CHIUSURA VANO INT. SIAT 2000
16	2.0000	PZ	S340002693Z	VITE TE M6X16 ZINCATA
17	2.0000	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
18	2.0000	PZ	S340000293Z	DADO M6 ZINCATO
19	1.0000	pz	SBA0002651	Rullo entrata/uscita
22	1.0000	pz	SBC0003443V	Piano scorrimento laterale
23	6.0000	PZ	S310098105Z	BUSSOLA 200A
24	6.0000	PZ	S340001593Z	VITE TCEI M6X25 ZINCATA
25	1.0000	PZ	S340004593Z	VITE TE M5X20 ZINCATA
26	2.0000	PZ	S340074592Z	RONDELLA DENT. X VITE M5 BRUN.
27	2.0000	PZ	S340002393Z	DADO M5 ZINCATO
29	1.0000	PZ	S3801216ZZZ	PASSACAVO GOMMA PER FORO /16.5
30	12.000	PZ	S3803667ZZZ	TAPPO DP-875 SIAT-2000
33	1.0000	PZ	SCB0000385	CILINDRO CENTRATORE PRA-40-125 SPECIALE
34	2.0000	PZ	S3802977ZZZ	REGOLATORE DI VELOCITA' EAS2201F-02-065
35	1.0000	PZ	S331510292Z	CANNOTTO ATTACCO CILINDRO SR4
36	1.0000	PZ	S340235693Z	VITE TCEI M8X80 UNI5931 DIN912 TUTTO FIL
37	1.0000	PZ	S340028393Z	DADO AUTOBLOCCANTE M8 BASSO ZINCATO
38	2.0000	PZ	S310155500A	GUIDA X MOLLA SR4
39	1.0000	PZ	S370014793Z	MOLLA PER COLONNE 22A ZINC.
40	1.0000	PZ	S331525300A	PERNO ATTACCO CILINDRO SR4
41	1.0000	PZ	S331558893A	DADO SPECIALE ATTACCO CILINDRO SR4
42	1.0000	PZ	S340002193Z	VITE TE M6X12 ZINCATA
43	1.0000	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
44	1.0000	PZ	S780433700B	AS77 SET RUOTE /80 SIAT 2000
45	4.0000	PZ	S3401501ZZZ	RUOTA /80 POLIDERNYL
48	1.0000	PZ	S780441300A	AS80-SET GAMBE SPECIALI SIAT 2000
49	4.0000	PZ	S300105196A	ETICH RIGHELLA MILLIMET. H=600 X GAMBA S
50	4.0000	PZ	S320245593Z	DISTANZIALE PER RUOTE SM481
51	4.0000	PZ	S320724493A	ATTACCO RUOTA AS77
52	4.0000	PZ	S340006293Z	RONDELLA PIANA X VITE M12 ZINC
53	4.0000	PZ	S340073593Z	DADO M12 AUTOBLOCCANTE
54	8.0000	PZ	S340041592Z	GRANO EIPP M8X8 BR.
55	1.0000	PZ	SBA0005314	Supporto tasto emergenza c/ins.SR46
56	1.0000	pz	SBC0003793V	Protezione anteriore leve
57	1.0000	pz	SBC0003792V	Protezione posteriore leve
58	1.0000	pz	SBA0004736	Profilo di chiusura dx c/ins.
59	1.0000	pz	SBA0004737	Profilo di chiusura sx c/ins.



SR46-S Gen. 2007 Fig. **15001/1**

Fig. 15001 BANCALE SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
1	1.0000	pz	SBA0004743	Bancale assemblato c/inserti
2	4.0000	PZ	S4304737ZZZ	GAMBA CON PIEDINO SA2 SR4
3	4.0000	PZ	M3101498ZZZ	PIEDINO SERIE 2000 NERO
4	4.0000	PZ	S300098295A	RIGHELLA MILLIM PER GAMBA H=440 SA2-SR4
5	4.0000	PZ	S320567193A	PIASTRINA FISS.GAMBA
6	4.0000	PZ	S320589893A	STAFFA PER GAMBE E TRAVERSE SIAT 2000
7	8.0000	PZ	S340058493Z	VITE TCEI M8X16 ZINCATA
8	10.000	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
10	6.0000	PZ	S340031893Z	VITE TCEI M5X12 ZINCATA
11	8.0000	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
12	1.0000	PZ	S320588847A	PIASTRA CHIUSURA VANO INT. SIAT 2000
16	2.0000	PZ	S340002693Z	VITE TE M6X16 ZINCATA
17	2.0000	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
18	2.0000	PZ	S340000293Z	DADO M6 ZINCATO
19	1.0000	pz	SBA0002651	Rullo entrata/uscita
22	1.0000	pz	SBC0003443V	Piano scorrimento laterale
23	6.0000	PZ	S310098105Z	BUSSOLA 200A
24	6.0000	PZ	S340001593Z	VITE TCEI M6X25 ZINCATA
25	1.0000	PZ	S340004593Z	VITE TE M5X20 ZINCATA
26	2.0000	PZ	S340074592Z	RONDELLA DENT. X VITE M5 BRUN.
27	2.0000	PZ	S340002393Z	DADO M5 ZINCATO
29	1.0000	PZ	S3801216ZZZ	PASSACAVO GOMMA PER FORO /16.5
30	12.000	PZ	S3803667ZZZ	TAPPO DP-875 SIAT-2000
33	1.0000	PZ	SCB0000385	CILINDRO CENTRATORE PRA-40-125 SPECIALE
34	2.0000	PZ	S3802977ZZZ	REGOLATORE DI VELOCITA' EAS2201F-02-065
35	1.0000	PZ	S331510292Z	CANNOTTO ATTACCO CILINDRO SR4
36	1.0000	PZ	S340235693Z	VITE TCEI M8X80 UNI5931 DIN912 TUTTO FIL
37	1.0000	PZ	S340028393Z	DADO AUTOBLOCCANTE M8 BASSO ZINCATO
38	2.0000	PZ	S310155500A	GUIDA X MOLLA SR4
39	1.0000	PZ	S370014793Z	MOLLA PER COLONNE 22A ZINC.
40	1.0000	PZ	S331525300A	PERNO ATTACCO CILINDRO SR4
41	1.0000	PZ	S331558893A	DADO SPECIALE ATTACCO CILINDRO SR4
42	1.0000	PZ	S340002193Z	VITE TE M6X12 ZINCATA
43	1.0000	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
44	1.0000	PZ	S780433700B	AS77 SET RUOTE /80 SIAT 2000
45	4.0000	PZ	S3401501ZZZ	RUOTA /80 POLIDERNYL
48	1.0000	PZ	S780441300A	AS80-SET GAMBE SPECIALI SIAT 2000
49	4.0000	PZ	S300105196A	ETICH RIGHELLA MILLIMET. H=600 X GAMBA S
50	4.0000	PZ	S320245593Z	DISTANZIALE PER RUOTE SM481
51	4.0000	PZ	S320724493A	ATTACCO RUOTA AS77
52	4.0000	PZ	S340006293Z	RONDELLA PIANA X VITE M12 ZINC
53	4.0000	PZ	S340073593Z	DADO M12 AUTOBLOCCANTE
54	8.0000	PZ	S340041592Z	GRANO EIPP M8X8 BR.
55	1.0000	PZ	SBA0005314	Supporto tasto emergenza c/ins.SR46
56	1.0000	pz	SBC0003793V	Protezione anteriore leve
57	1.0000	pz	SBC0003792V	Protezione posteriore leve
58	1.0000	pz	SBA0004736	Profilo di chiusura dx c/ins.
59	1.0000	pz	SBA0004737	Profilo di chiusura sx c/ins.

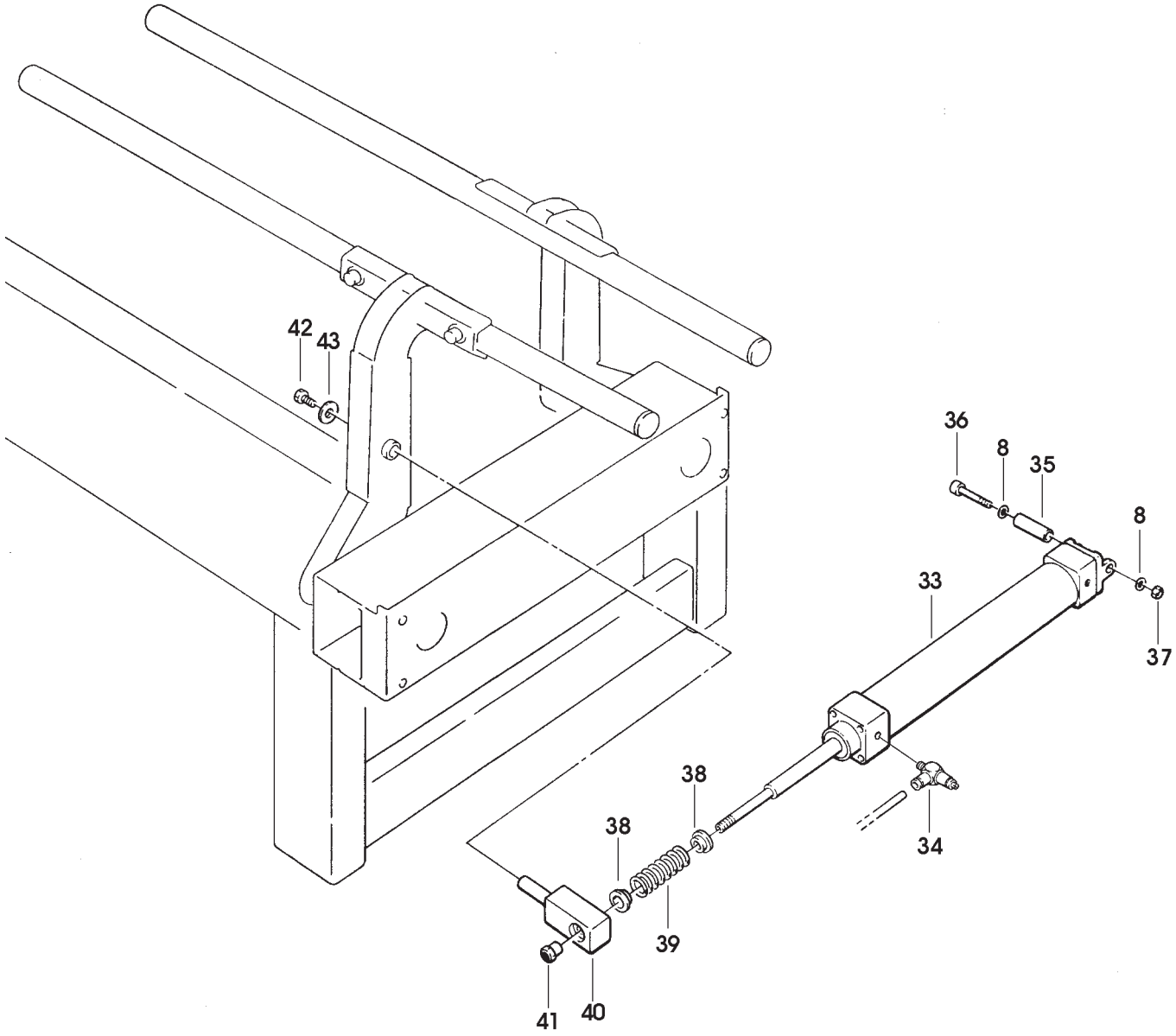

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Fig. 15002 IMPIANTO PNEUMATICO BANCALE SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
1	1.0000	PZ	SBA0005338	RIDUTTORE PRESSIONE CENTRATORE ASS.
2	1.0000	PZ	SBA0005339	RIDUTTORE PRESSIONE DISCESA TEST. ASS.
3	1.0000	PZ	SBA0005341	VALVOLA SALITA/DISCESA ASSEMBLATA
4	1.0000	PZ	SCB0000363	Gr. comando pneumatico 220V-AC / SR46
5	1.0000	PZ	SBA0005343	VALVOLA SELETTRICE ASSEMBLATA
6	4.0000	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
7	2.0000	PZ	S340014193Z	VITE TCEI M5X25 ZINCATA
8	2.0000	PZ	S340002393Z	DADO M5 ZINCATO
9	1.0000	pz	SCB0000329	Elettrovalvola G 1/4"-220V- R412006267
10	1.0000	PZ	S3805113ZZZ	TUBO PNEUM.TUO604B (5M)
11	1.0000	PZ	S3805112ZZZ	TUBO PNEUM.TUO425B (M5)
12	1.0000	PZ	SCB0000426	NUOVO GR. PNEUM. INGRESSO 230V-MpA
13	1.0000	PZ	SCB0000425	NUOVO GRUPPO PNEUM. INGRESSO 24V-DC
14	1.0000	PZ	SCB0000424	NUOVO GRUPPO PNEUM. INGRESSO 24V-AC
15	1.0000	PZ	SCB0000423	NUOVO GRUPPO PNEUM. INGRESSO 110V
16	1.0000	PZ	SCB0000422	NUOVO GRUPPO PNEUM. INGRESSO 230V
17	1.0000	PZ	SCB0000433	PILOTA D016 24V-DC
18	1.0000	PZ	SCB0000432	PILOTA D016 24V-AC
19	1.0000	PZ	SCB0000431	PILOTA D016 110V-AC

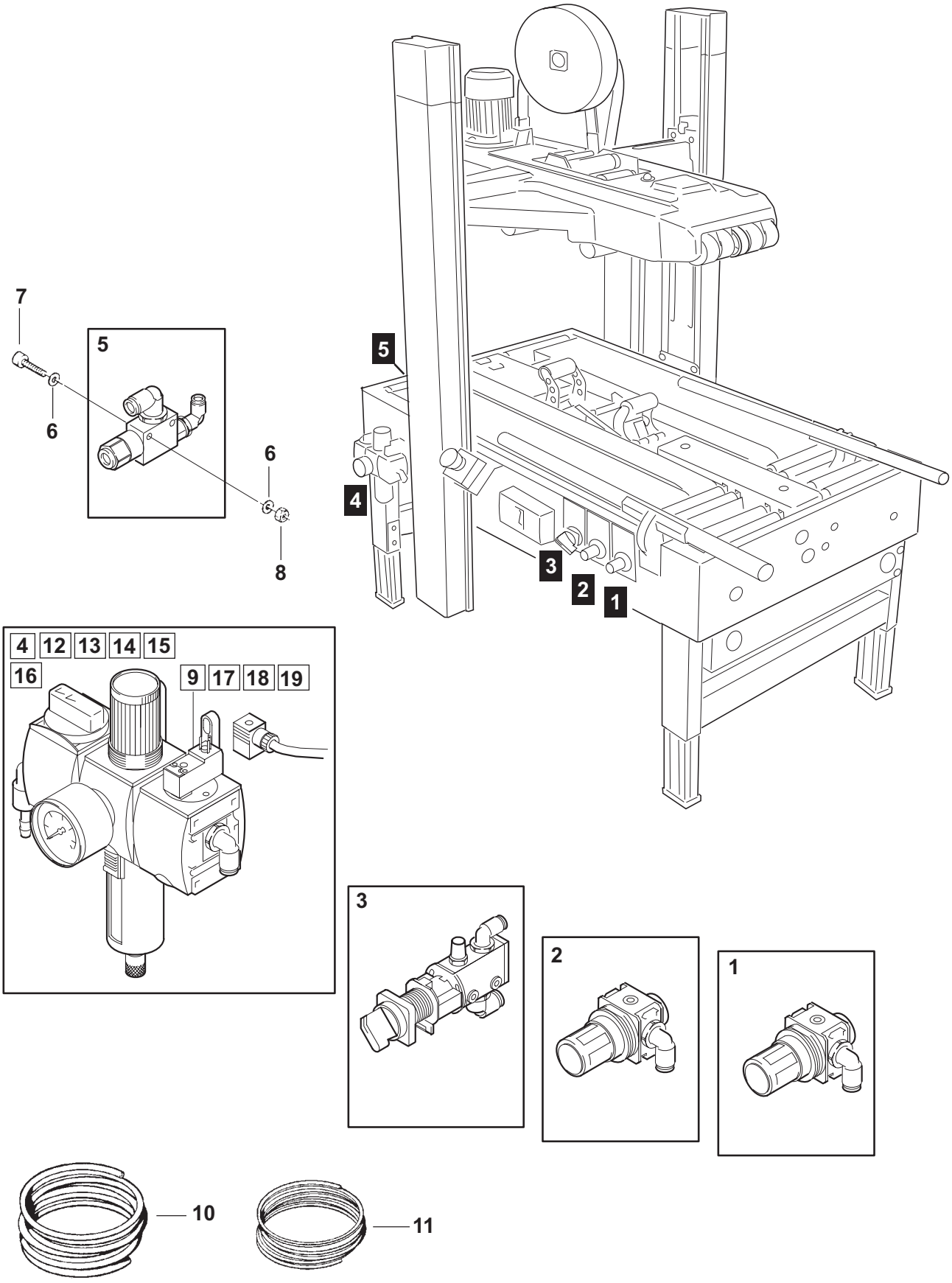
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Fig. 15003 MOTORIZZAZIONE SUPERIORE SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
2	1.0000	pz	SBA0002665	Struttura motorizzazione sup. c/ins.
3	2.0000	PZ	S340001293Z	VITE TCBCR M4X10 ZINCATA
4	4.0000	PZ	S340000193Z	DADO M4 ZINCATO
5	1.0000	PZ	S3803595ZZZ	RIDUTT.MOTOVARIO 1:20 ALBERO
6	3.0000	PZ	S340011293Z	VITE TCEI M5X16 ZINCATA
8	28.000	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
9	2.0000	PZ	S331606293A	DISTANZIALE X PULEGGE MOTRICI SA2 SR4
10	2.0000	PZ	S4705876ZZZ	PULEGGIA MOTRICE ASS.C/ANELLI
11	4.0000	PZ	S310054048Z	ANELLO PER PULEGGIA
12	2.0000	PZ	S350051593Z	DADO SPEC.AUTOBLOCC.M20X1 ZINC
13	2.0000	PZ	S470852800B	CARRELLO TENDICINGHIA ASS.SA2 SR4
14	2.0000	PZ	S440568793C	CARRELLO TENDICINGHIA ASS. SA2 SR4 ZINC.
15	2.0000	PZ	S4601730ZZZ	PULEGGIA FOLLE COMP.
16	2.0000	PZ	S330491693Z	RONDELLA /6,5/30X5
17	2.0000	PZ	S340002492Z	RONDELLA ELASTICA X M6
18	3.0000	PZ	S340057793Z	VITE TCEI M6X16 ZINCATA
19	2.0000	PZ	S350180293Z	DIST.PERNO MOT.INF. 200A-700A-700R 3M
20	2.0000	PZ	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
21	2.0000	PZ	S340040693Z	VITE TE M8X60 ZINCATA
22	10.000	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
23	4.0000	PZ	S320290993Z	GUIDA SCORRIM.CINGHIA 200A
24	8.0000	PZ	S340005593Z	VITE TSVEI M5X20 ZINCATA
25	2.0000	PZ	S3401771ZZZ	CING TRASCINAM.C/GIUNZ 75X1823 +-2,5 S2
26	1.0000	pz	SBA0002159V	Carter post. ass. motorizzazione sup.
27	11.000	PZ	S340072093Z	VITE TESTA MEZZA TONDA M5X12 CROCE ZINC.
28	1.0000	pz	SBA0003249	Valvola superiore ass.
31	1.0000	pz	SBA0003248	Squadra sx fissaggio valvola c/ins.
32	1.0000	pz	SBA0003247	Squadra dx fissaggio valvola c/ins.
33	1.0000	PZ	S340022993Z	VITE TCEI M4X30 ZINCATA
34	1.0000	PZ	S340000193Z	DADO M4 ZINCATO
35	5.0000	PZ	S340031893Z	VITE TCEI M5X12 ZINCATA
36	1.0000	PZ	S332217593A	PERNO RULLI ENTRATA SA26 W=1300 ZINC.
37	1.0000	PZ	S310066240Z	LEVA AZIONAMENTO VALVOLA
38	2.0000	PZ	S340021993Z	RONDELLA PIANA X VITE M10 ZINC
39	2.0000	PZ	S340018792Z	ANELLO ARRESTO 10 DIN 471 BRUN
40	1.0000	PZ	S332957893A	PERNO PER CAMMA TESTATA 700r/3" - SR46
41	4.0000	PZ	S310102205Z	RULLO ENTRATA MOTORIZZ.700R
42	2.0000	PZ	S331538793A	PERNO X RULLO ENTRATA ESTERNO SA2 SR4
43	5.0000	PZ	S340002193Z	VITE TE M6X12 ZINCATA
44	3.0000	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
45	1.0000	PZ	SCB0000195	VALVOLA 3/2 - 6x1
47	1.0000	PZ	S3800622ZZZ	RACCORDO GOMITO GIR.31990410
48	1.0000	PZ	S3800618ZZZ	RACCORDO DIR.M.CIL.31010610
49	1.0000	PZ	SBA0005340	VALVOLA SCARICO RAPIDO ASSEMBLATA
50	1.0000	PZ	S3803850ZZZ	VALVOLA SYJA712-01F
51	1.0000	PZ	S3803852ZZZ	RACCORDO GOMITO 31820600
52	1.0000	PZ	S3800668ZZZ	RACCORDO T CENTR.GIR.31980610
53	1.0000	PZ	S3800739ZZZ	RACCORDO GOMITO GIR.31990419

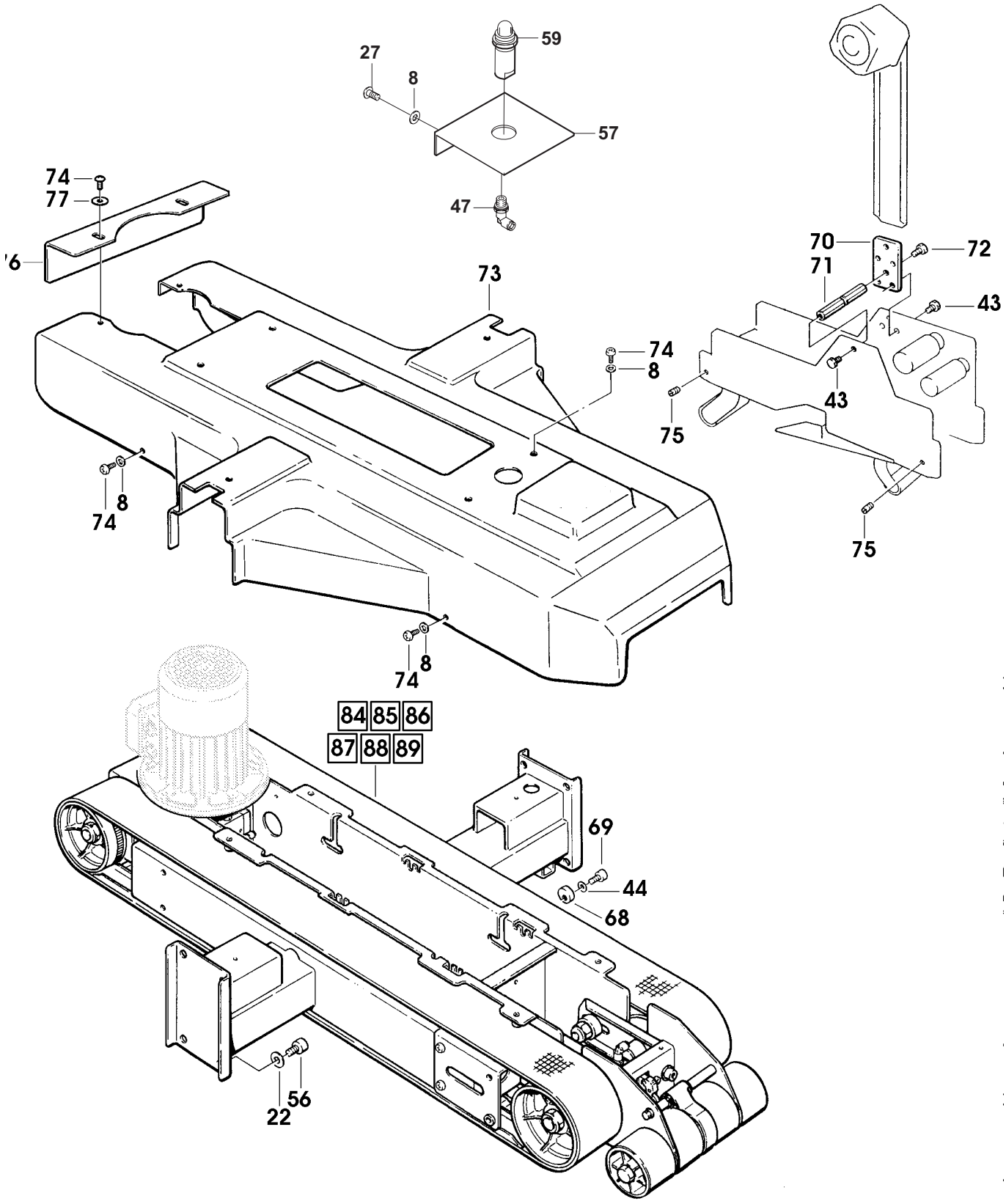
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Fig. 15003 MOTORIZZAZIONE SUPERIORE SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
55	1.0000	PZ	S450492047Z	STAF SX FIXGIO PROT SUP.C/INS. S2 SA2 SR
56	8.0000	PZ	S340058993Z	VITE TCEI M8X14 ZINCATA
57	1.0000	pz	SBC0007224V	Staffa indicatore ottico
59	1.0000	PZ	S3802123ZZZ	INDICATORE OTTICO VR 3100-1 700R/3M
67	2.0000	PZ	S340004393Z	RONDELLA PIANA X VITE M4 ZINC.
68	1.0000	PZ	S331577093B	FERMO PER UNITA' NASTRANTE TOP SA2-SR4
69	1.0000	PZ	S340005193Z	VITE TCEI M6X12 ZINCATA
70	1.0000	PZ	S331569793A	STAF ATTACCO ARM PORTAROT SIAT 2000
71	1.0000	PZ	S330808693Z	DISTANZIALE ESAGONALE 10X107
72	1.0000	PZ	S340005793Z	VITE TE M6X20 ZINCATA
73	1.0000	PZ	SBC0001533	Protezione antinfortunistica superiore
74	12.000	PZ	S340170893Z	VITE TESTA MEZZA TONDA CROCE M5X16 PER 7
75	4.0000	PZ	S350207193Z	ATTACCO UNITA'K13/14 ZINC.
76	1.0000	pz	SBC0002510V	Protezione cinghie motorizzazione sup.
77	2.0000	PZ	S340046893Z	RONDELLA TRIPLA X VITE M5 ZINC
84	1.0000	pz	SBA0004783	MOT. SUP. 100V 50/60HZ MH63 SR46 KYOWA
85	1.0000	pz	SBA0004781	MOT. SUP. 110/115V 60HZ MH63 SR46
86	1.0000	pz	SBA0004782	MOT. SUP. 220/230/240V 50HZ MH63 SR46
87	1.0000	pz	SBA0004779	MOT. SUP. 220/240V 50HZ H63 SR46
88	1.0000	pz	SBA0004785	MOT. SUPER. 220V 60HZ MH63 SR46
89	1.0000	pz	SBA0004780	MOT. SUPERIORE 440V 50HZ H63 SR46
90	1.0000	pz	SBC0004015	Distanziale rulli entrata

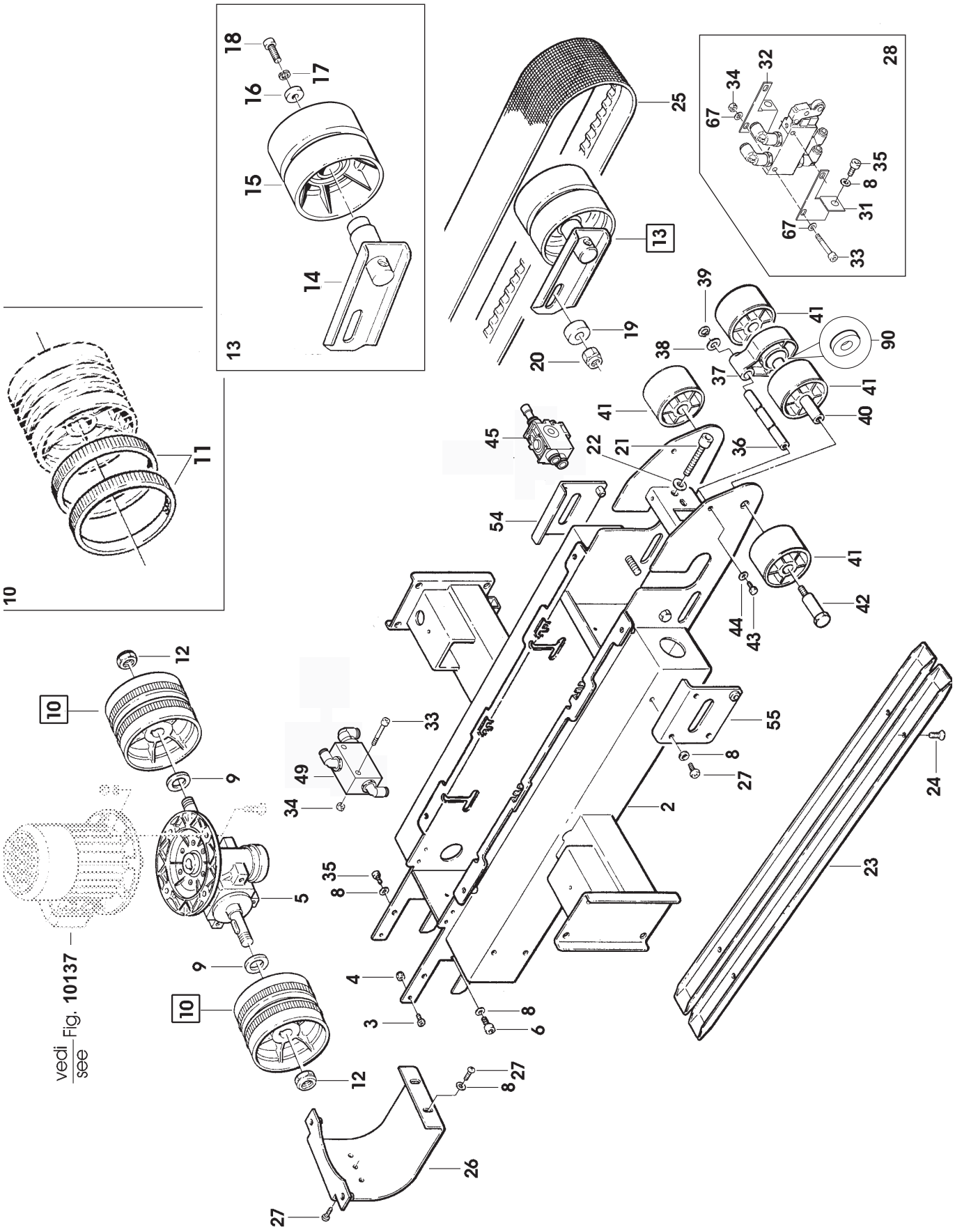
vedi Fig. 10137
see

Fig. 15004 COLONNE SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
3	1.0000	pz	SBA0003010	Colonna fissa con bandella
4	1.0000	pz	SBC0004392T	Piastrina fissaggio colonna
5	32.000	PZ	S340136592Z	GRANO EIPC DENTELLATO M8X10 BR
6	2.0000	PZ	S320585393A	PIASTRA DI BASE X COLONNA SIAT 2000
7	8.0000	PZ	S340269893Z	VITE TCEE M10X35 DIN 7984 SIAT 2000
8	8.0000	PZ	S340220692Z	RANELLA DI SAFETY "S" (SCHNORR) /10 F144
9	1.0000	PZ	SBA0003246	Colonna scorrevole ass.
10	1.0000	PZ	SCB0000177	CILINDRO PER COLONNE SR46
11	2.0000	PZ	S331513693A	BUSSOLA ATTACCO CILINDRO SIAT 2000
12	2.0000	PZ	S3803251ZZZ	SILENZIATORE SP 1/4" SM11/94
13	1.0000	PZ	SBA0005267	Protezione colonna scorrevole ass. SR46
14	4.0000	PZ	S310154800A	PATTINO X PROTEZIONE COLONNE
15	8.0000	PZ	S3400984ZZZ	RIVETTO /4
16	16.000	PZ	S320567396Z	PIASTR FIX BEARING TROPICAL
17	24.000	PZ	S3402623ZZZ	(C) CUSCINETTO A SFERE SIAT 2000
18	16.000	PZ	S331348693Z	VITE PER CUSCINETTO SIAT-2000
19	8.0000	PZ	S331348893Z	RONDELLA SIAT 2000 ZIN.
20	8.0000	PZ	S331348993Z	RONDELLA /18X8 SP.1 SA2/SR4
21	8.0000	PZ	S320567293Z	PIASTRINA FISSAGGIO COLONNA S2000
22	5.0000	PZ	S320604493B	PIASTR X PROT COLON SIAT 2000 ZINC.
23	2.0000	PZ	S310071905A	ROND.AMMORTIZ./22/35X5 NERO
24	2.0000	PZ	S350051593Z	DADO SPEC.AUTOBLOCC.M20X1 ZINC
25	8.0000	PZ	S340058993Z	VITE TCEI M8X14 ZINCATA
26	8.0000	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
27	2.0000	PZ	S310148947A	PROTEZIONE COLONNA FISSA SIAT 2000
28	4.0000	PZ	S331643993B	PIASTR FIX PROT SUP.COLON ZINC.
29	1.0000	PZ	S440584447B	SUPPORTO AMMORTIZZATORE ASS. SIAT 2000
30	1.0000	PZ	S310102105Z	TAMPONE AMMORTIZZATORE 700R 3M
31	1.0000	PZ	S3402699ZZZ	MANIGLIA A RIPRESA "ELESA" GN 125 D M8X1
32	1.0000	PZ	S330535393Z	RONDELLA /8,5X25X4
33	1.0000	PZ	S331564393B	VITE SPEC X REG ALTEZ SIAT 2000 ZINC.
34	1.0000	PZ	S340003393Z	RONDELLA TRIPLA X VITE M6 ZINC
35	1.0000	PZ	S340025893Z	DADO AUTOBLOCCANTE M6 ZINC.
36	2.0000	PZ	S3803673ZZZ	RIDUZIONE CONICA 1/4"M-1/4"F L MAX.25mm
37	2.0000	PZ	S3800617ZZZ	RACCORDO GOMITO GIR.31990613
38	2.0000	PZ	S3801006ZZZ	TAPPO RA 019 1/8" CILINDRICO

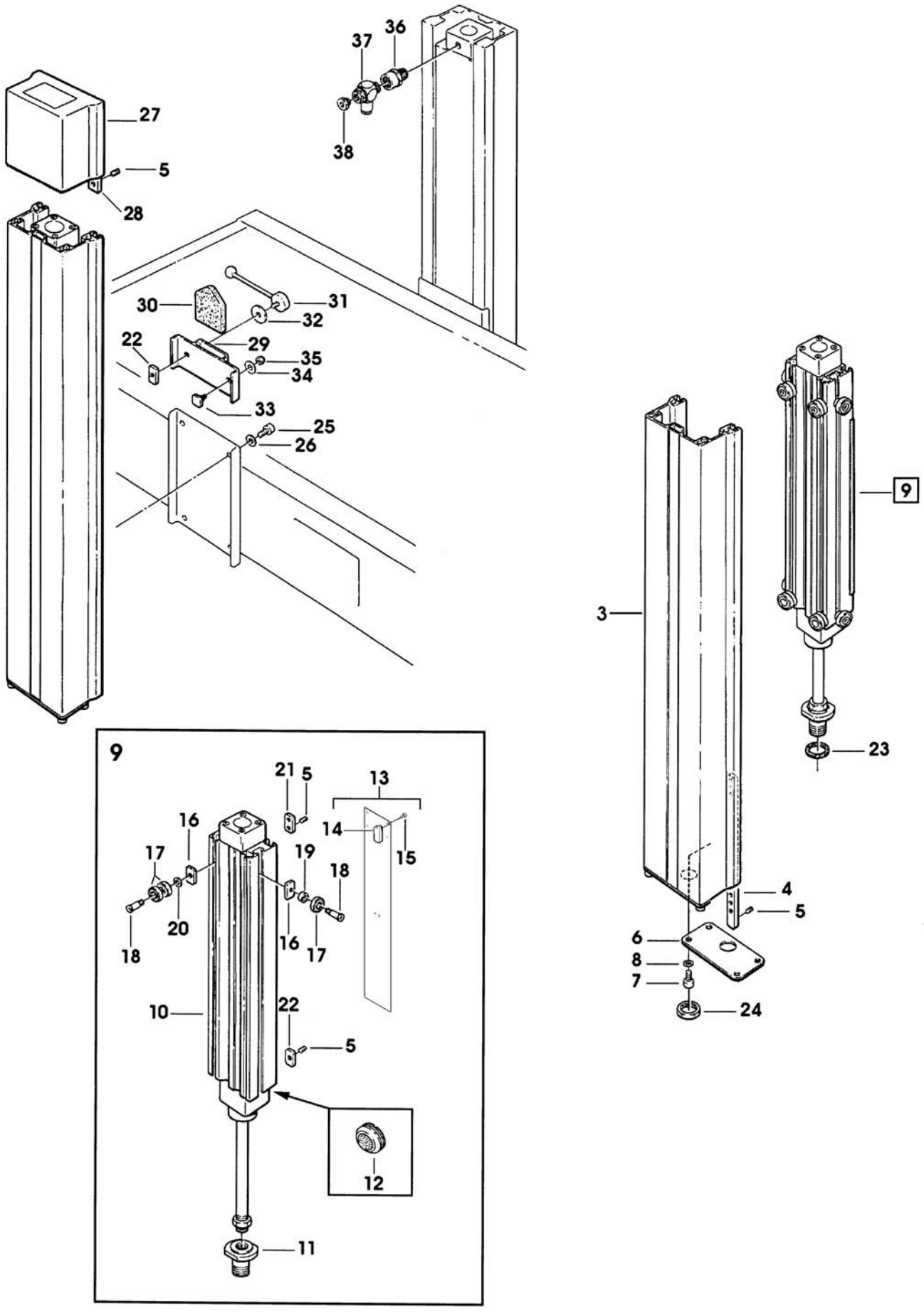
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Fig. 15005 CANALINA SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
1	1.0000	pz	SBA0003014	Canalina assemblata c/guarnizione
2	4.0000	PZ	S340057793Z	VITE TCEI M6X16 ZINCATA
3	4.0000	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.
4	1.0000	PZ	S3801403ZZZ	PASSACAVO GOMMA CON MEMBR "EZ DG16" PER
5	1.0000	pz	SBC0003967V	Coperchio per canalina
6	8.0000	PZ	S340072093Z	VITE TESTA MEZZA TONDA M5X12 CROCE ZINC.
7	12.000	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
8	1.0000	PZ	S370015547Z	MOLLA A BANDELLA SM46/94
9	2.0000	PZ	S340037193Z	VITE TE M5X12 ZINCATA
10	4.0000	PZ	S340002393Z	DADO M5 ZINCATO
11	1.0000	PZ	S320635693A	SQUADRETTA ATTACCO BANDELLA SA2 SR4
14	1.0000	M	S3802207ZZZ	GUAINA FLESSIBILE /16
15	2.0000	PZ	S380809200A	CONNET QUICKON-ONE DA 0.75 A 1.5 Q 1,5/
16	1.0000	PZ	S3802400ZZZ	RACCORDO KQH04-00 800af
17	1.0000	PZ	S3802139ZZZ	BOCCHETTONE SKINTOP ST11
18	5.0000	PZ	S3801241ZZZ	FASCETTA L=140x3,5 (NERA)
20	2.0000	PZ	S3802031ZZZ	RACCORDO 1/2" DIR.X GUAINA /19
21	1.0000	PZ	S3802401ZZZ	RACCORDO KQH08-00 800af
22	1.0000	PZ	S3801682A	RACCORDO Y FEMM.LEGRIS31400400

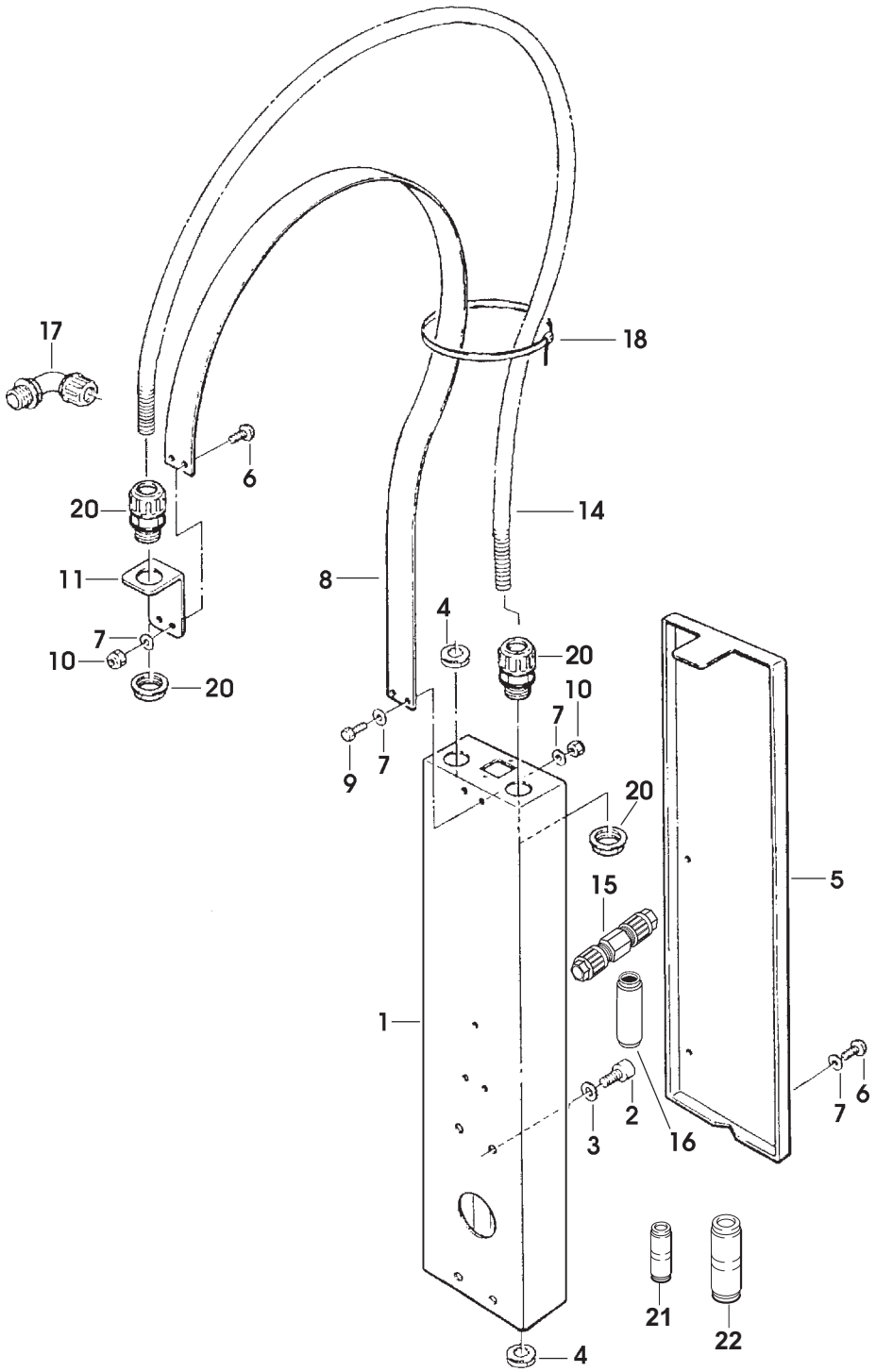
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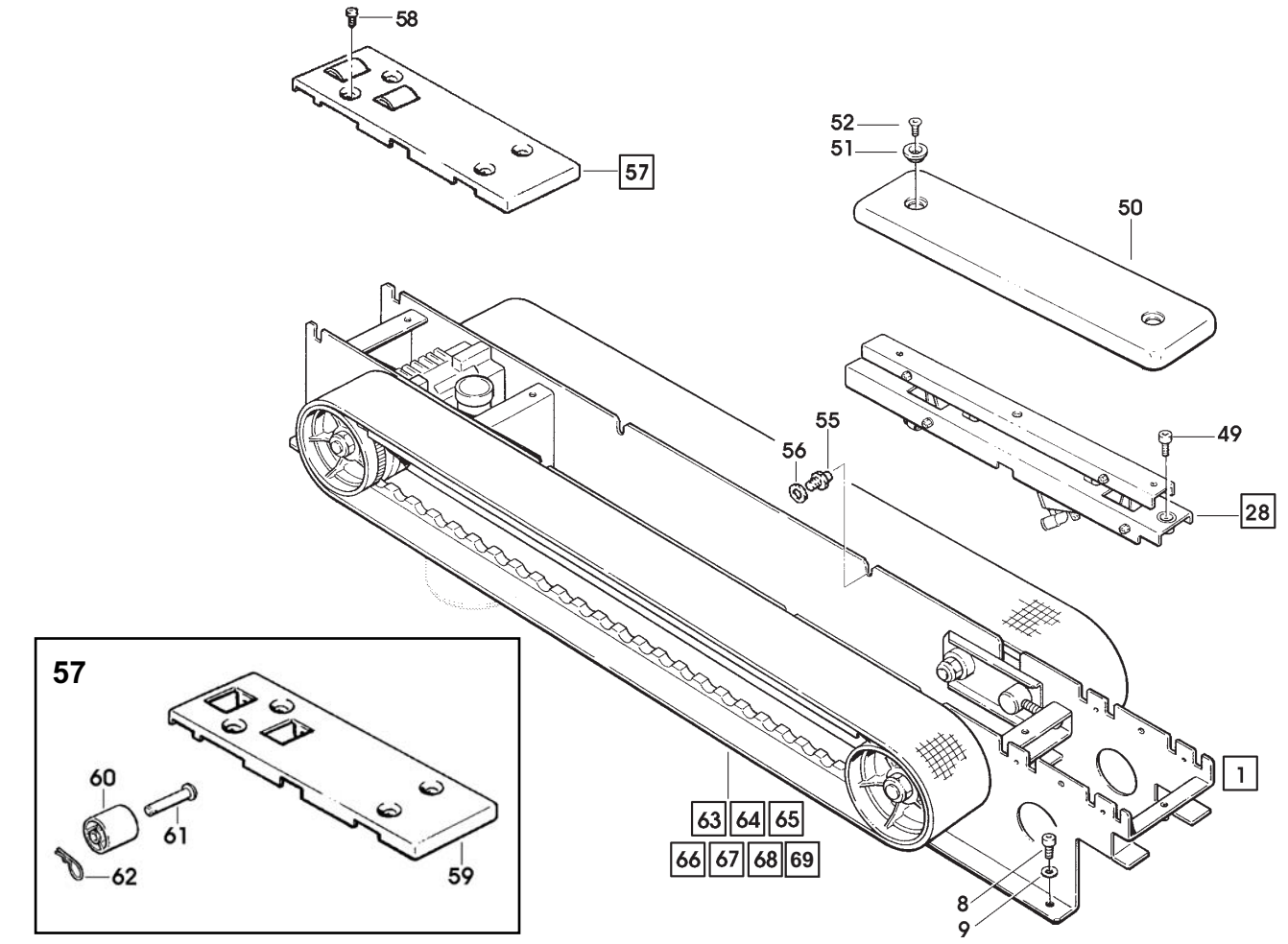
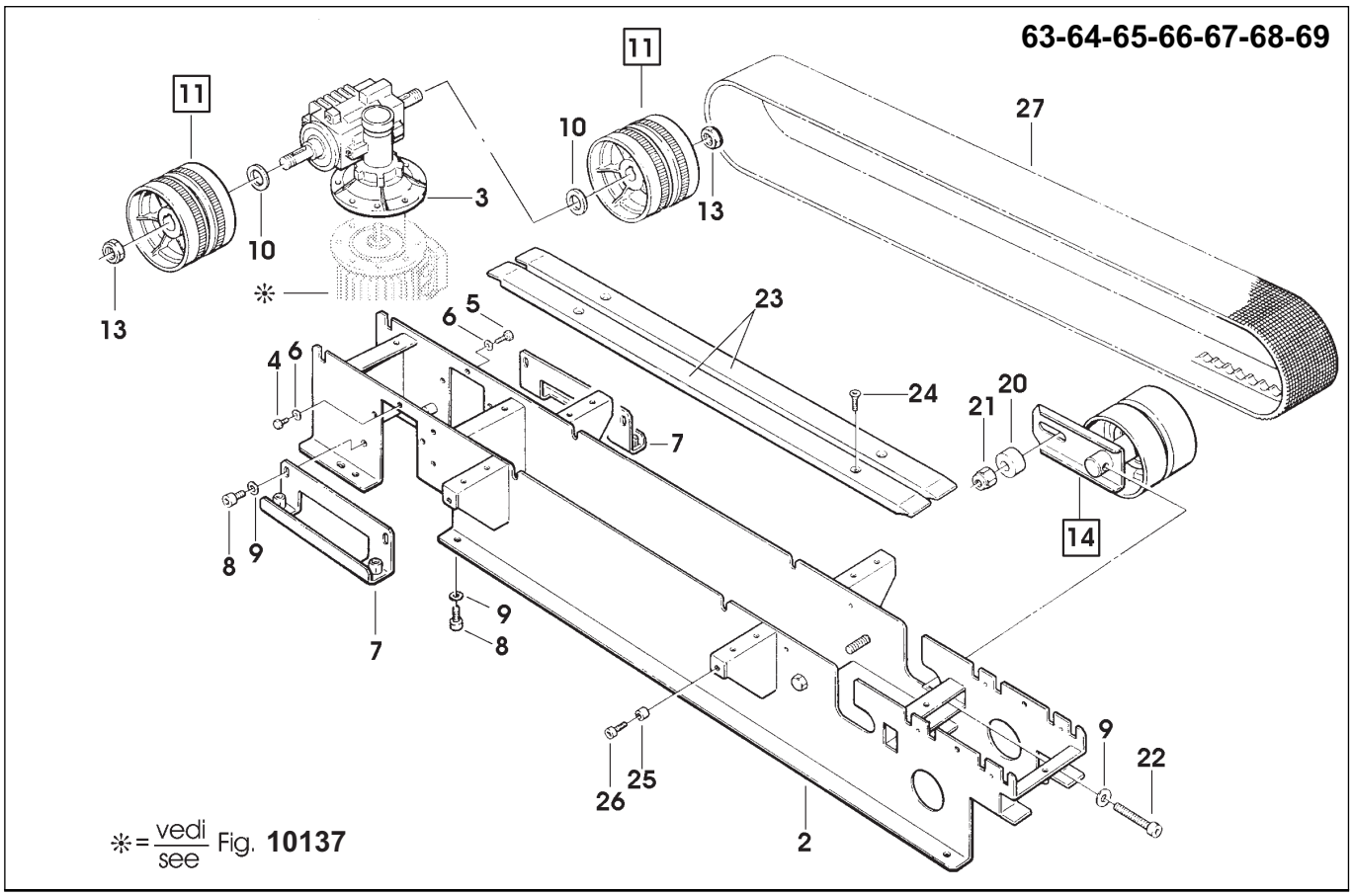
Fig. 15006 MOTORIZZAZIONE INFERIORE SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
2	1.0000	pz	SBA0003002	Struttura motorizz. inf. c/ins.
3	1.0000	PZ	S3803595ZZZ	RIDUTT.MOTOVARIO 1:20 ALBERO
4	3.0000	PZ	S340037193Z	VITE TE M5X12 ZINCATA
5	3.0000	PZ	S340032993Z	VITE TE M5X16 ZINCATA
6	15.000	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
7	2.0000	PZ	S450491247Z	SQUADRETTA RINFORZO SPALLE S2 SA2 SR4
8	12.000	PZ	S340058493Z	VITE TCEI M8X16 ZINCATA
9	14.000	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
10	2.0000	PZ	S331606293A	DISTANZIALE X PULEGGE MOTRICI SA2 SR4
11	2.0000	PZ	S4705876ZZZ	PULEGGIA MOTRICE ASS.C/ANELLI
12	4.0000	PZ	S310054048Z	ANELLO PER PULEGGIA
13	2.0000	PZ	S350051593Z	DADO SPEC.AUTOBLOCC.M20X1 ZINC
14	2.0000	PZ	S470852800B	CARRELLO TENDICINGHIA ASS.SA2 SR4
15	2.0000	PZ	S440568793C	CARRELLO TENDICINGHIA ASS. SA2 SR4 ZINC.
16	2.0000	PZ	S4601730ZZZ	PULEGGIA FOLLE COMP.
17	2.0000	PZ	S330491693Z	RONDELLA /6,5/30X5
18	2.0000	PZ	S340002492Z	RONDELLA ELASTICA X M6
19	2.0000	PZ	S340057793Z	VITE TCEI M6X16 ZINCATA
20	2.0000	PZ	S350180293Z	DIST.PERNO MOT.INF. 200A-700A-700R 3M
21	2.0000	PZ	S340043893Z	DADO AUTOBLOCCANTE M10 BASSO
22	2.0000	PZ	S340170393Z	VITE TCEI M8X70 TUTTO FILET 200A-700A 3M
23	4.0000	PZ	S320290993Z	GUIDA SCORRIM.CINGHIA 200A
24	8.0000	PZ	S340005593Z	VITE TSVEI M5X20 ZINCATA
25	4.0000	PZ	S350185293Z	DIST.X CARTER LAT.200A-700A
26	4.0000	PZ	S340004593Z	VITE TE M5X20 ZINCATA
27	2.0000	PZ	S3401771ZZZ	CING TRASCINAM.C/GIUNZ 75X1823 +-2,5 S2
28	1.0000	pz	SBA0003299	Gruppo azionamento valvola inferiore
29	1.0000	PZ	S440582247B	SUPPORTO LEVA INF.ASS.SR4 SR46
30	1.0000	PZ	S450485247Z	LEVA INF.CON INSERTI SR4
31	1.0000	PZ	S310083705Z	CAMMA AZIONAM.VALVOLE
32	1.0000	PZ	S4204225ZZZ	CAMMA CON GOMMA
33	2.0000	PZ	S331525093Z	DISTANZIALE X LEVA
34	2.0000	PZ	S331525193Z	DISTANZIALE X SUPPORTO
35	2.0000	PZ	S340038293Z	VITE TCEI M5X40 ZINCATA
36	2.0000	PZ	S340056393Z	VITE TCEI M5X55 ZINCATA
37	5.0000	PZ	S340025993Z	DADO AUTOBLOCCANTE M5 ZINCATO
38	1.0000	PZ	S340022893Z	VITE TCBCR AUTOF.8PX13 ZINCATA
39	1.0000	PZ	S330580093Z	PERNO ATTACCO MOLLA
40	1.0000	PZ	S370022794Z	MOLLA PORTALAMA K9-K13/3M NIK.
41	1.0000	pz	SBA0003298	Valvola inferiore assemblata
45	2.0000	PZ	S340272793Z	VITE TCEI M3X35 ZINCATA
46	4.0000	PZ	S340055893Z	RONDELLA PIANA X VITE M3 ZINC.
47	2.0000	PZ	S340034193Z	DADO ESAGONALE M3
48	2.0000	PZ	S331611993A	DISTANZIALE X VALVOLA INF.SR4
49	2.0000	PZ	S340016093Z	VITE TCEI M6X20 ZINCATA
50	1.0000	PZ	S320591240A	CARTER PER LEVE INF.SA2-SR4
51	2.0000	PZ	S331537293B	RONDELLA PER FISSAGGIO CARTER LEVA ZINC.
52	2.0000	PZ	S340005393Z	VITE TSVEI M6X16 ZINCATA

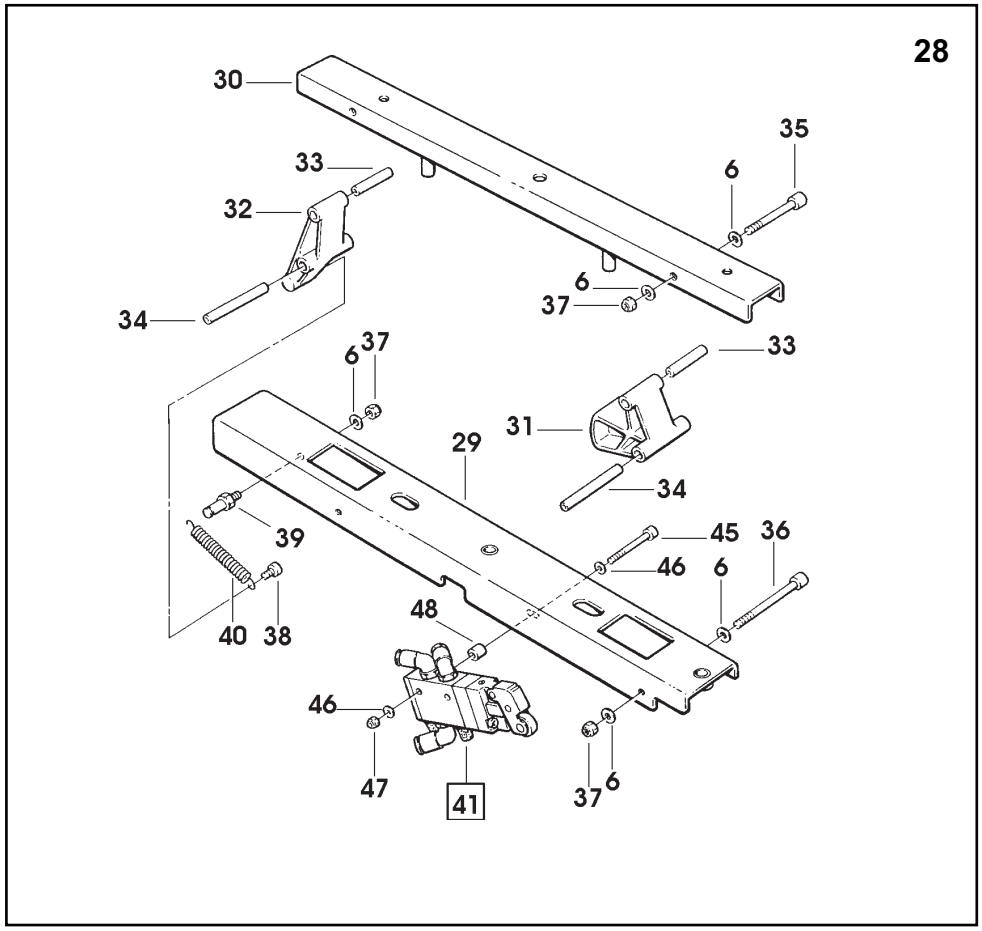




SR46-S Gen. 2007 Fig. **15006/1**

Fig. 15006 MOTORIZZAZIONE INFERIORE SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
55	4.0000	PZ	S350179493Z	PERNO ATTACCO UNITA'SUP.-INF.
56	4.0000	PZ	S320387698Z	ROND INOX X BEARING GR. ENTRATA K13
57	1.0000	pz	SBA0002883	Pianetto a rulli posteriore ass.
58	4.0000	PZ	S340170893Z	VITE TESTA MEZZA TONDA CROCE M5X16 PER 7
59	1.0000	pz	SBC0003815V	Pianetto a rulli posteriore
60	2.0000	PZ	S3100564ZZZ	RULLINO /32X38
61	2.0000	PZ	S331070293Z	PERNO X RULLINI BANCALE 800a3M
62	2.0000	PZ	S370001296Z	MOLLETTA H75/H100 800a/800ab
63	1.0000	pz	SBA0004777	MOT. INFER 100V 50/60HZ MH63 SR46 KYOWA
64	1.0000	pz	SBA0004775	MOT. INFER. 110/115V 60HZ MH63 SR46
65	1.0000	pz	SBA0004772	MOT. INFER. 200/220V 50/60HZ H63 SR46
66	1.0000	pz	SBA0004776	MOT. INFER. 220/230/240V 50HZ MH63 SR46
67	1.0000	pz	SBA0004773	MOT. INFER. 220/240V 50HZ H63 SR46
68	1.0000	pz	SBA0004784	MOT. INFER. 220V 60HZ MH63 SR46
69	1.0000	pz	SBA0004774	MOT. INFERIORE 440V 50HZ H63 SR46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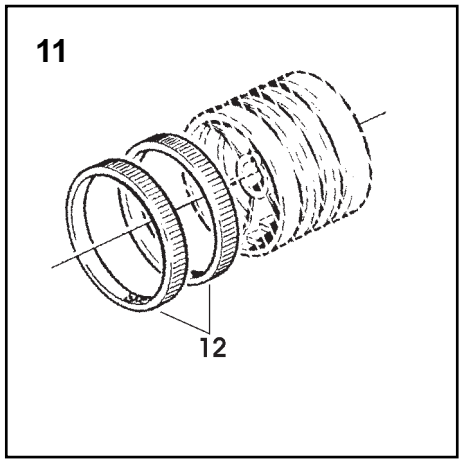
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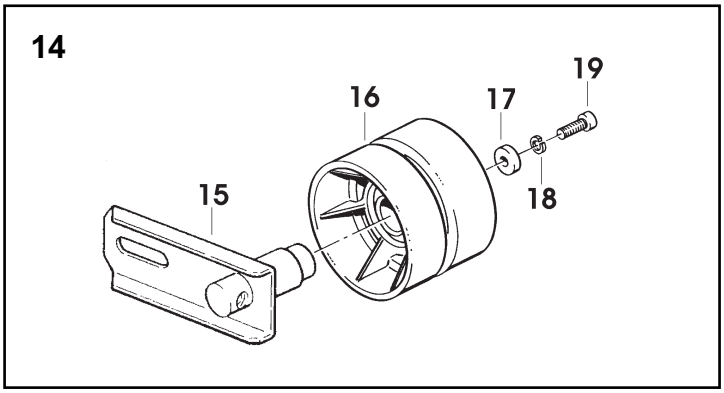
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Fig. 15007 CENTRATORE SEB0000372 SR46-S NASTRATRICE

Pos.	Q.tà	UM	Codice	Descrizione
1	1.0000	pz	SBA0004517	Gruppo centratore leve
2	1.0000	pz	SBA0004255	Cassonetto centratore c/ins.
3	4.0000	PZ	S3400156A	CUSCINETTO 6005-2RS1 SKF NTN
4	2.0000	PZ	S330958292Z	ALBERO PER LEVE CENTRATORE BR. AS24
5	2.0000	PZ	S3400238ZZZ	LINGUETTA 6X6X20
6	2.0000	PZ	S331611793A	DISTANZIALE X LEVE SA2 SR4
7	2.0000	PZ	S3400641ZZZ	LINGUETTA 6X6X25
8	2.0000	PZ	S330958693Z	DISTANZIALE X CUSCIN.AS24 ZINC
9	2.0000	PZ	S330958793Z	(C) PIGNONE CON MOZZO 3/8"Z=20 ZINCATO
10	2.0000	PZ	S340059992Z	GRANO EIPP M6 X 8
11	1.0000	pz	SCA0000363	Spezzone catena aperto P=3/8" L=38passi
12	1.0000	pz	SCA0000362	Spezzone catena aperto P=3/8" L=57passi
13	2.0000	PZ	S320103793Z	TIRANTE X CATENA SM/XL/3M
14	2.0000	PZ	S330560593Z	RONDELLA /3/10X3 ZINCATA
15	1.0000	PZ	S330618592Z	VITE SPEC.TC M3X25
16	4.0000	PZ	S340101493Z	DADO AUTOBLOCCANTE M3 ZINCATO
17	1.0000	PZ	S330560493Z	BLOCCHETTO FISS.CATENA
18	2.0000	PZ	S340090592Z	ANELLO SICUREZZA 3,2 DIN 6799
19	2.0000	PZ	S330560293Z	VITE TENDICAT.DX/SX SM4/F-104
20	2.0000	PZ	S340000293Z	DADO M6 ZINCATO
21	1.0000	PZ	S330589993Z	FORCELLA DESTRORSA SM4/F-104
22	2.0000	PZ	S330560393Z	FORCELLA SINISTROSA F-104
23	3.0000	PZ	S330618492Z	VITE SPEC.TC M3X20
24	2.0000	PZ	S440581440A	LEVA ASS.SA2 SR4
25	2.0000	PZ	S340004893Z	VITE TSVEI M8X16 ZINCATA
26	2.0000	PZ	S330958393Z	RONDELLA CENTRATORE AS24 ZINC.
27	4.0000	PZ	S340012293Z	VITE TCEI M8X20 ZINCATA
28	4.0000	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
29	1.0000	pz	SBC0003789V	Carter centratore
30	1.0000	pz	SBC0006386T	Distanziale fissaggio carter cassonetto
31	1.0000	PZ	S340012393Z	RONDELLA PIANA X VITE M8 ZINC.
32	1.0000	PZ	S340032493Z	VITE TE M8X16 ZINCATA
33	1.0000	PZ	S470898700B	GUIDA PER SCATOLE ASS.SR4
34	4.0000	PZ	S340016093Z	VITE TCEI M6X20 ZINCATA
35	4.0000	PZ	S340017593Z	RONDELLA PIANA X VITE M6 ZINC.

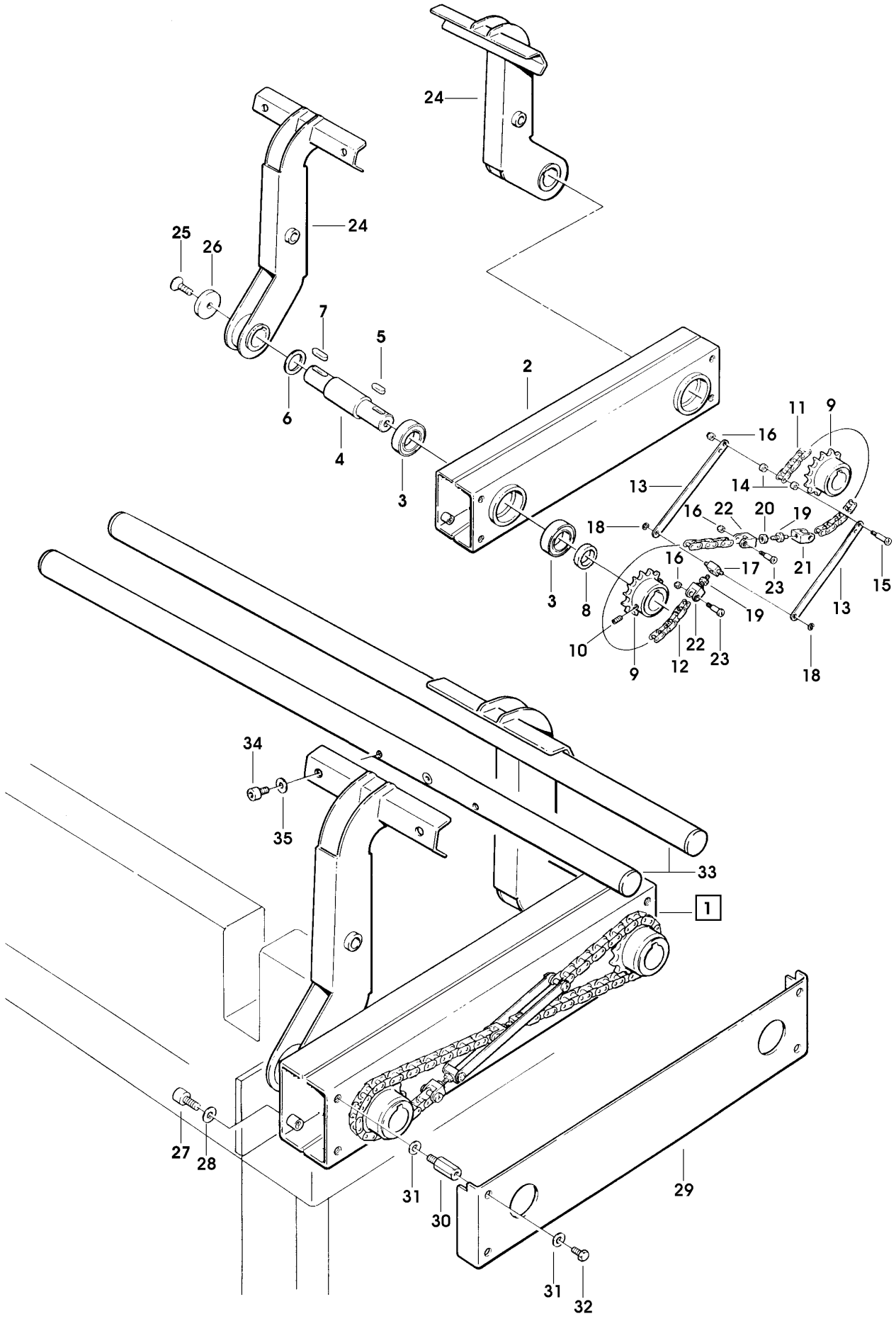
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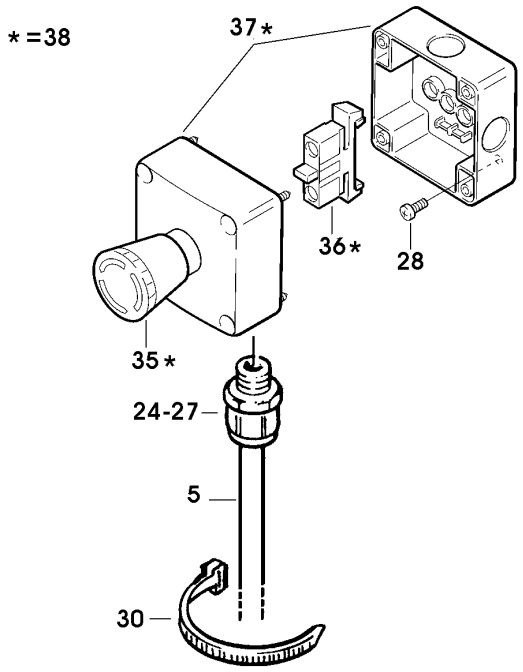
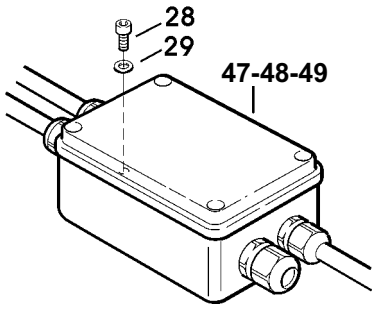
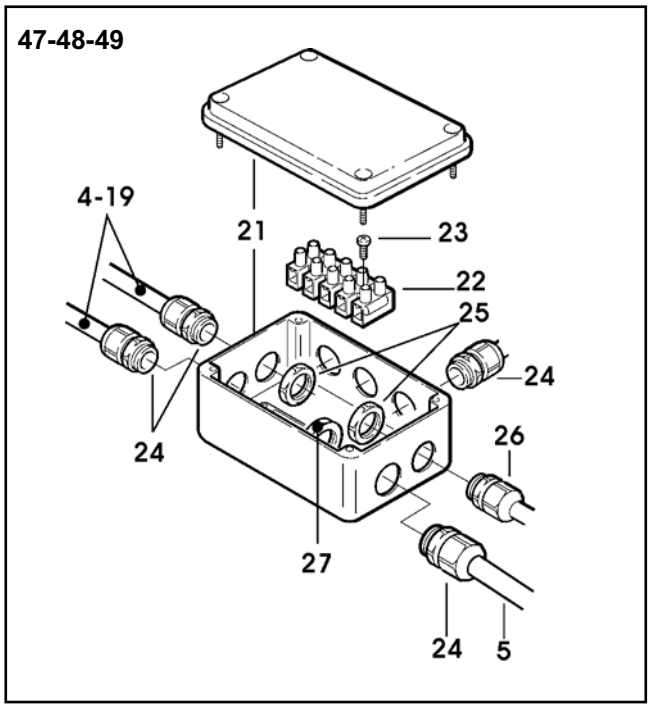
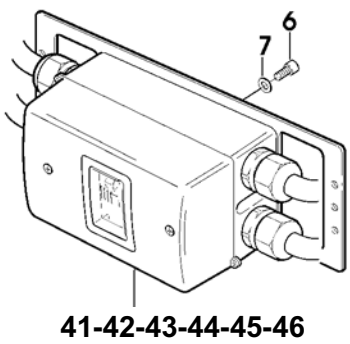
Fig. 15008 GRUPPO IMPIANTO ELETTRICO SEB0000372 SR46-S NASTRATRICE

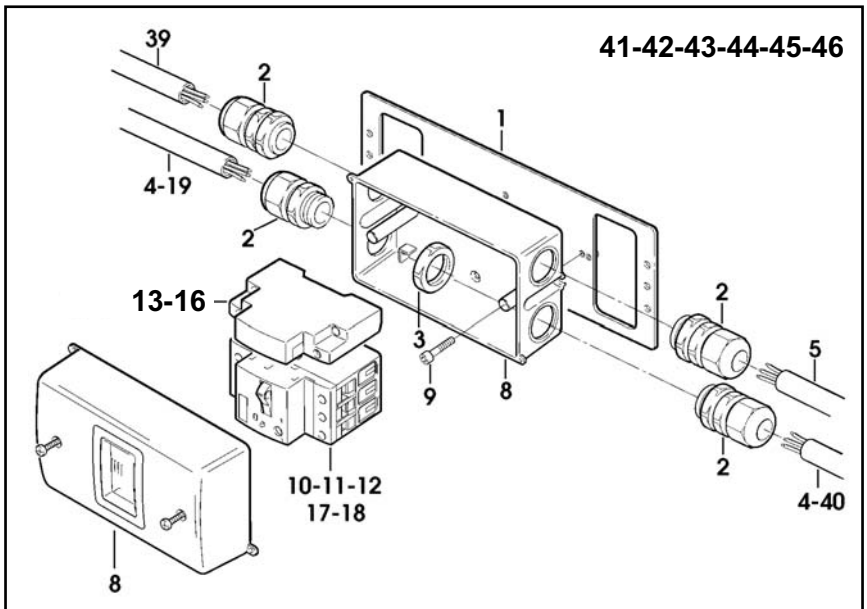
Pos.	Q.tà	UM	Codice	Descrizione
1	1.0000	PZ	S450487147Z	SUPPORTO INTERRUTTORE C/INSERTI SA2 SR4
2	4.0000	PZ	S3800854ZZZ	BOCCHETTONE SKINTOP ST 16
3	4.0000	PZ	S3803846ZZZ	CONTRODADO GMP16
4	2.0000	PZ	S3801704ZZZ	CAVO VIN.3X1,5 MT.5 X MF
5	1.0000	PZ	S3802654ZZZ	CAVO 3X1 C/2 ROSSI + 1 GIALLO/ VERDE (MT
6	4.0000	PZ	S340031893Z	VITE TCEI M5X12 ZINCATA
7	4.0000	PZ	S340006193Z	RONDELLA PIANA X VITE M5 ZINC.
8	1.0000	PZ	S3805125ZZZ	CUSTODIA ISOLANTE 3ZV1913-1A S00 IP55 SI
9	2.0000	PZ	S340013093Z	VITE TSVEI M4X15 ZINCATA
11	1.0000	PZ	S3805117ZZZ	INTER.AUT. 3RV1011-1BA10 S00 1.4-2A 100K
12	1.0000	PZ	S3805120ZZZ	INTER.AUT. 3RV1011-1HA10 S00 5.5-8A 100K
13	1.0000	PZ	S3805122ZZZ	BOBINA DI MINIMA TENS 230V 3RV1902-1AP0
16	1.0000	PZ	S3805121ZZZ	BOBINA DI MINIMA TENS 110V 3RV1902-1AF0
17	1.0000	PZ	S3805116ZZZ	INTER.AUT. 3RV1011-0KA10 S00 0.9-1.25A 1
18	1.0000	PZ	S3805119ZZZ	INTER.AUT. 3RV1011-1FA10 S00 3.5-5A 100K
19	2.0000	PZ	S3801703ZZZ	CAVO VIN.4X1,5 MT.5 X 3F
21	1.0000	PZ	S3802389ZZZ	CASSETTA DI DERIVAZIONE 120X80X50 800af
22	0,4100	PZ	S3801480ZZZ	MORSETTIERA NYLON D.10 12PEZZI
23	2.0000	PZ	S340218193Z	VITE TCBCR AUTOF.4,2X19 800af
24	9.0000	PZ	S3802139ZZZ	BOCCHETTONE SKINTOP ST11
25	7.0000	PZ	S3802143ZZZ	CONTRODADO GMP11
26	1.0000	PZ	S3802141ZZZ	BOCCHETTONE SKINTOP ST13,5
27	2.0000	PZ	S3802144ZZZ	CONTRODADO GMP13,5
28	4.0000	PZ	S340039093Z	VITE TCEI M4X12 ZINCATA
29	2.0000	PZ	S340004393Z	RONDELLA PIANA X VITE M4 ZINC.
30	2.0000	PZ	S3801241ZZZ	FASCETTA L=140x3,5 (NERA)
35	1.0000	PZ	S3805198ZZZ	PULSANTE EMERG. 3SB3000-1HA20
36	1.0000	PZ	S3805197ZZZ	CONTATTO NC 3SB3420-0C
37	1.0000	PZ	S3805196ZZZ	SCATOLA GIALLA 3SB3801-0AC
38	1.0000	PZ	S471168900A	PULSANTE EMERGENZA ASS.SM/XL "SIEMENS"
39	1.0000	PZ	S3803701ZZZ	CAVO FROR 07 3X1 (MT5)
40	2.0000	PZ	S3802989ZZZ	CAVO FROR 07 5X1,5 GRIGIO MT.5
41	1.0000	PZ	SBB0001065	INT.ASS. SR46 200/220V 50/60HZ 3F
42	1.0000	PZ	SBB0001071	INT.ASS. SR46 100V 50/60HZ MF KYOWA
43	1.0000	PZ	SBB0001069	INT.ASS. SR46 115V 60HZ MF
44	1.0000	PZ	SBB0001070	INT.ASS. SR46 220/240V 50HZ MF
45	1.0000	PZ	SBB0001070	INT.ASS. SR46 220/240V 50HZ MF
46	1.0000	PZ	SBB0001067	INT.ASS. SR46 440V 50HZ 3F
47	1.0000	PZ	SBB0001073	SCATOLA DI DERIVAZIONE SR46 MF 110V
48	1.0000	PZ	SBB0001074	SCATOLA DI DERIVAZIONE SR46 MF
49	1.0000	PZ	SBB0001072	SCATOLA DI DERIVAZIONE SR46 3F





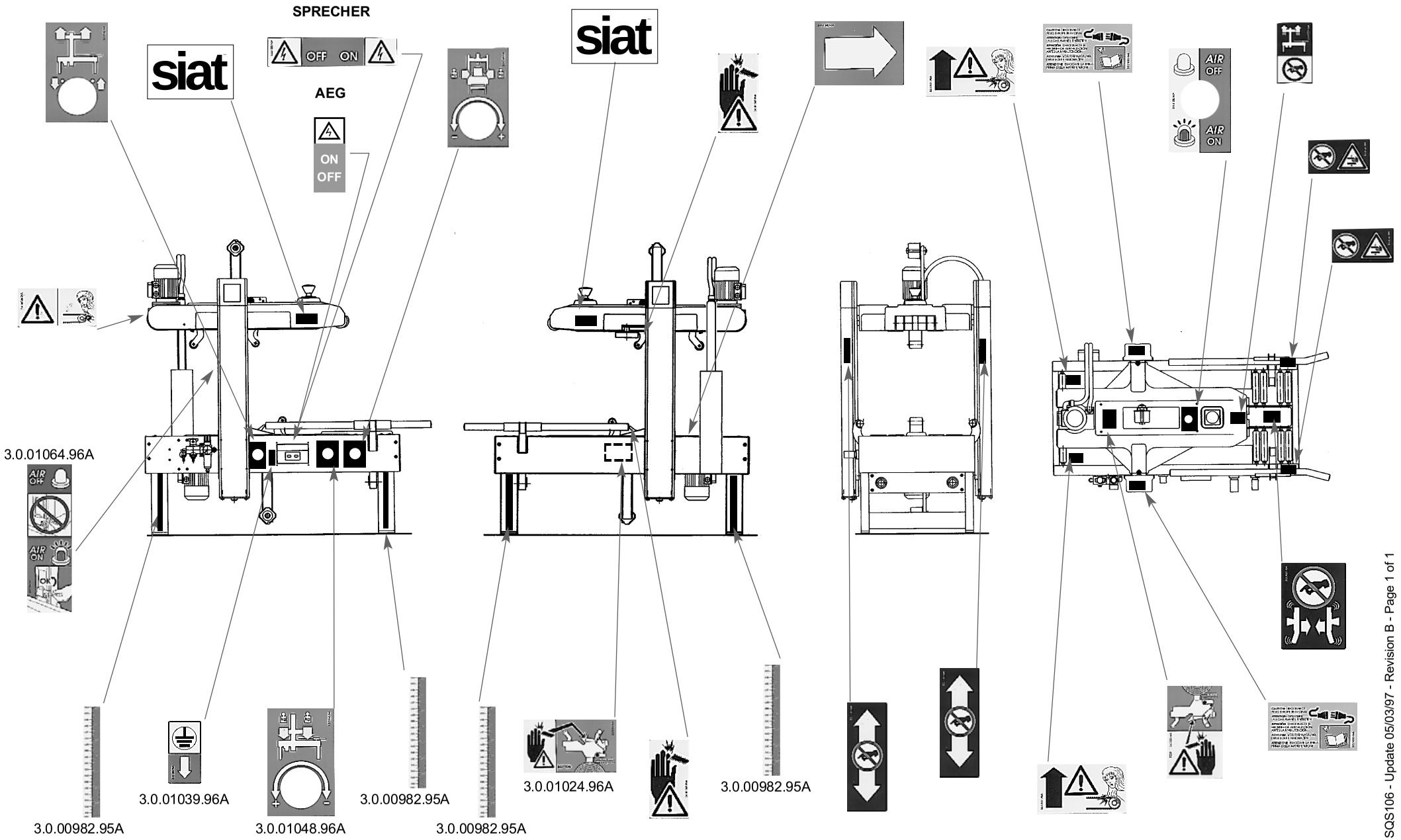






10 = 200/240V 3F
12 = 100/115V MF - 220V 60Hz MF
17 = 380/440V 3F
18 = 220/240V 50Hz MF

SIAT S.p.A. - Via Puecher, 22 - 22078 TURATE (CO) ITALY - P.O. BOX 1
Tel. 02-964951 - Telefax 02-9689727
http://www.siat.com - E-Mail: siat@siat.com



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SR46-S LABELS - ETIQUETTES - ETIQUETAS- ETIKETTEN - ETICHETTE Fig. **5709**